UNISAW fi
Left Tilt 10" Tilting Arbor Saw
(Model 36-960)

INSTRUCTION MANUAL

DATED 6-27-00

PART NO. 422-40-651-0003

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DELTA

SAFETY RULES

Woodworking can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. Safety equipment such as guards, push sticks, hold-downs, featherboards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won t make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workshop. If a procedure feels dangerous, don t try it. Figure out an alternative procedure that feels safer. REMEMBER: Your personal safety is your responsibility.

This machine was designed for certain applications only. Delta Machinery strongly recommends that this machine not be modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, DO NOT use the machine until you have first contacted Delta to determine if it can or should be performed on the product.

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WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

1. FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE TOOL. Learn the tool s application and limitations as well as the specific hazards peculiar to it.

2. KEEP GUARDS IN PLACE and in working order.

3. ALWAYS WEAR EYE PROTECTION.

4. GROUND ALL TOOLS. If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter lug must be attached to a known ground. Never remove the third prong.

5. REMOVE ADJUSTING KEYS AND WRENCHES. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.

6. KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents.

7. DON T USE IN DANGEROUS ENVIRONMENT. Don t use power tools in damp or wet locations, or expose them to rain. Keep work area well-lighted.

8. KEEP CHILDREN AND VISITORS AWAY. All children and visitors should be kept a safe distance from work area.

9. MAKE WORKSHOP CHILDPROOF with padlocks, master switches, or by removing starter keys.

10. DON T FORCE TOOL. It will do the job better and be safer at the rate for which it was designed.

11. USE RIGHT TOOL. Don t force tool or attachment to do a job for which it was not designed.

12. WEAR PROPER APPAREL. No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Nonslip footwear is recom-mended. Wear protective hair covering to contain long hair.

13. ALWAYS USE SAFETY GLASSES. Wear safety glasses. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses. Also use face or dust mask if cutting operation is dusty.

14. SECURE WORK. Use clamps or a vise to hold work when practical. It s safer than using your hand and frees both hands to operate tool.

15. DON T OVERREACH. Keep proper footing and balance at all times.

16. MAINTAIN TOOLS IN TOP CONDITION. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

17. DISCONNECT TOOLS before servicing and when changing accessories such as blades, bits, cutters, etc.

18. USE RECOMMENDED ACCESSORIES. The use of accessories and attachments not recommended by Delta may cause hazards or risk of injury to people.

19. REDUCE THE RISK OF UNINTENTIONAL START-ING. Make sure switch is in OFF position before plugging in power cord.

20. NEVER STAND ON TOOL. Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.

21. CHECK DAMAGED PARTS. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in this instruction manual. Have defective switches replaced by authorized service center. Do not use tool if switch does not turn it on and off.

22. DIRECTION OF FEED. Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.

23. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. Don t leave tool until it comes to a complete stop.

24. DRUGS, ALCOHOL, MEDICATION. Do not operate tool while under the influence of drugs, alcohol or any medication.

25. MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY while motor is being mounted, connected or reconnected.

26. WHEN THE TOOL IS NOT IN USE, the switch should be locked in the OFF position to prevent unauthorized use of the tool.

27. WARNING: The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use wood dust collection systems whenever possible.

ADDITIONAL SAFETY RULES FOR CIRCULAR SAWS

1. WARNING: Do not operate your saw until it is completely assembled and installed according to the instructions.

2. IF YOU ARE NOT thoroughly familiar with the operation of circular saws, obtain advice from your supervisor, instructor, or other qualified person.

3. ALWAYS use guard, splitter and anti-kickback fingers on all thru-sawing operations. Thru-sawing operations are those when the blade cuts completely through the workpiece as in ripping or cross-cutting.

4. ALWAYS hold the work firmly against the miter gage or fence.

5. NEVER use the fence as a cut-off gage when cross-cutting.

6. MOVE the rip fence out of the way when crosscutting.

7. NEVER perform any operation free-hand which means using your hands to support or guide the workpiece. Always use either the fence or miter gage to position and guide the work.

8. ALWAYS use a push stick for ripping narrow stock. Refer to ripping applications in instruction manual where the push stick is covered in detail.

9. AVOID kickbacks (work thrown back toward you) by:
   A. Keeping blade sharp.
   B. Keeping rip fence parallel to the saw blade.
   C. Keeping splitter and anti-kickback fingers and guard in place and operating.
   D. Not releasing the work before it is pushed all the way past the saw blade.
   E. Not ripping work that is twisted or warped or does not have a straight edge to guide along the fence.

10. AVOID awkward operations and hand positions where a sudden slip could cause your hand to move into the cutting tool.

11. ALWAYS keep hands and fingers away from the blade.

12. NEVER stand or have any part of your body in line with the path of the saw blade.

13. NEVER reach behind or over the cutting tool with either hand for any reason.

14. DIRECTION OF FEED. Feed work into blade or cutter against the direction or rotation of the blade or cutter only.

15. DO NOT feed the material too fast while cutting. Feed the material only fast enough so that the blade will cut.

16. NEVER attempt to free a stalled saw blade without first turning the saw OFF.

17. NEVER start the saw with the workpiece pressed against the blade.

18. NEVER turn the saw ON before clearing the table of all objects (tools, scraps of wood, etc.).

19. ALWAYS STOP the saw before removing scrap pieces from the table.

20. NEVER perform layout, assembly or set-up work on the table while the saw is operating.

21. PROVIDE adequate support to the rear and sides of the saw table for wide or long workpieces.

22. WHEN cutting mouldings, NEVER run the stock between the fence and the moulding cutterhead.

23. NEVER use solvents to clean plastic parts. Solvents could possibly dissolve or otherwise damage the material. Only a soft damp cloth should be used to clean plastic parts.

24. SHOULD any part of your circular saw be missing, damaged, or fail in any way, or any electrical components fail to perform properly, shut off switch and remove plug from power supply outlet. Replace missing, damaged or failed parts before resuming operation.

25. ADDITIONAL INFORMATION regarding the safe and proper operation of this product is available from the National Safety Council, 1121 Spring Lake Drive, Itasca, IL 60143-3201, in the Accident Prevention Manual for Industrial Operations and also in the Safety Data Sheets provided by the NSC. Please also refer to the American National Standards Institute ANSI 01.1 Safety Requirements for Woodworking Machinery and the U.S. Department of Labor OSHA 1910.213 Regulations.

26. DUST CREATED BY POWER SANDING, SAWING, AND OTHER CONSTRUCTION ACTIVITIES contains chemicals from building materials that are known to cause cancer, and birth defects or other reproductive harm.

Some examples of these chemicals are:

Lead from lead-based paints

Crystalline Silica from bricks and cement

Arsenic and Chromium from chemically-treated lumber

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals:

Use wet sanding methods.

Work in a well-ventilated area.

Work with approved safety equipment. (Standard dust masks DO NOT filter out the harmful microscopic particles of these chemicals.)

SAVE THESE INSTRUCTIONS. Refer to them often and use them to instruct others.

FOREWORD

The Platinum Edition 10" Unisaw is a very powerful machine. The motor is single phase, 3 horse power, 230 volt motor that turns the circular blade at 4000 RPMs.

The Unisaw is a versatile machine, in that it can do precision ripping, cross-cutting, dadoing, moulding and tenoning.

MACHINE DATA

Diameter of Arbor	5/8" (16 mm)
Diameter of Blade	10" (254 mm)
Blade Speed (with 3450 rpm motor)	4000 rpm
Capacities:	
Maximum depth of cut	3 1/8" (79 mm)
Maximum rip to right of blade With Biesemeyer Commercial Saw Fence System	50" (1270 mm)
Maximum rip to left of blade With Biesemeyer Fence	12" (305 mm)
Maximum thickness of cut at 45"	2 1/8" (54 mm)
Distance; front of table to center of blade	16 13/16" (427 mm)
Table in front of saw blade At maximum depth of cut	12 1/4" (311 mm)
Maximum width of dado	13/16" (21 mm)

Table:	
Height	34" (864 mm)
Size with Extension Wing And Biesemeyer Table Board	74" x 27" (1880x686 mm)
T-Slot Miter Gage Groove	3/8" x 3/4" (10x19 mm)
Overall Dimensions:	
Height	36 3/4" (933 mm)
Width with Wings and Guide Bar	45 3/8" (1152 mm)
Width with Wing And Biesemeyer 50" Guide Bar	84" (2134 mm)
Depth	35 3/4" (908 mm)
Depth with Biesemeyer Rip Fence	42" (1067 mm)

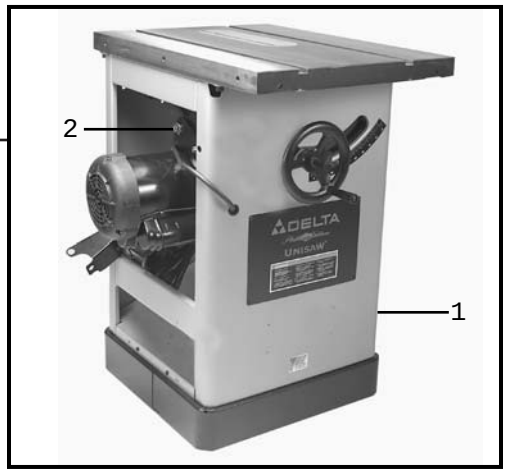

Fig. 1

UNPACKING AND CLEANING

Carefully unpack the saw and fence system from the shipping containers. Clean all loose parts and remove the protective coating from the machined surfaces of the saw table. This coating may be removed with a soft cloth moistened with WD-40® (do not use acetone, gasoline, or lacquer thinner for this purpose). Figures 1, 2, 3, 4, and 5, illustrate the saw and all loose items supplied with the machine.

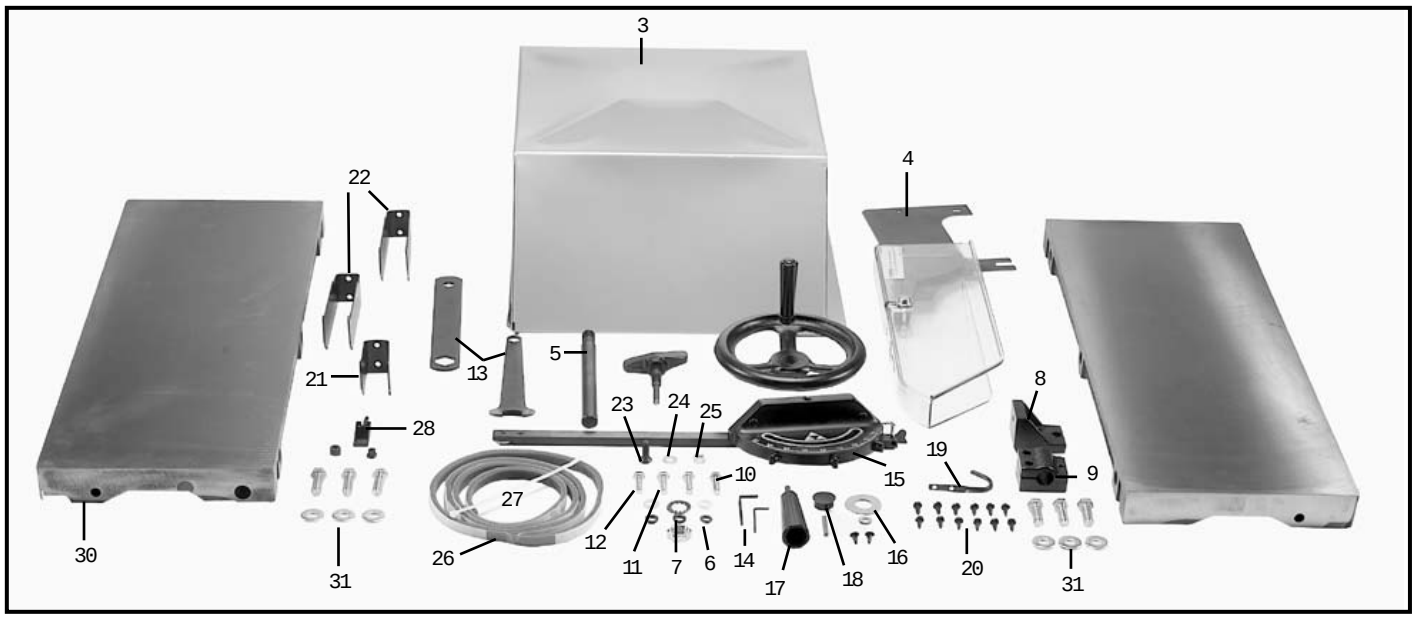

Fig. 2

1. Unisaw
2. Switch
3. Motor cover
4. Blade guard and splitter bracket
5. Support rod
6. 5/8" Internal tooth washer
7. 5/8-18 Jamb nut
8. Upper bracket for splitter
9. Lower bracket for support rod
10. 5/16" I.D. Flat washers (2)
11. 5/16" I.D. Lockwashers (3)
12. 5/16-18 x 1" Hex head cap screws (4)
13. Arbor wrenches (2)
14. 1/4" and 3/8" Hex wrenches
15. Miter gage
16. Flat washer for miter gage
17. Handle for miter gage handle
18. Cap for miter gage handle
19. Storage hook for arbor wrenches
20. #10 x 1/2" hex washer head screws (10)
21. Hanger for miter gage
22. Hangers for rip fence (2)
23. Flat head screw for mounting switch
24. Flat washer for mounting switch
25. Hex nut for mounting switch
26. Gasket for motor cover
27. Cable tie
28. Latch for motor cover
29. Square cornered cast iron extension wing (right)
30. Square cornered cast iron extension wing (left)
31. Mounting hardware

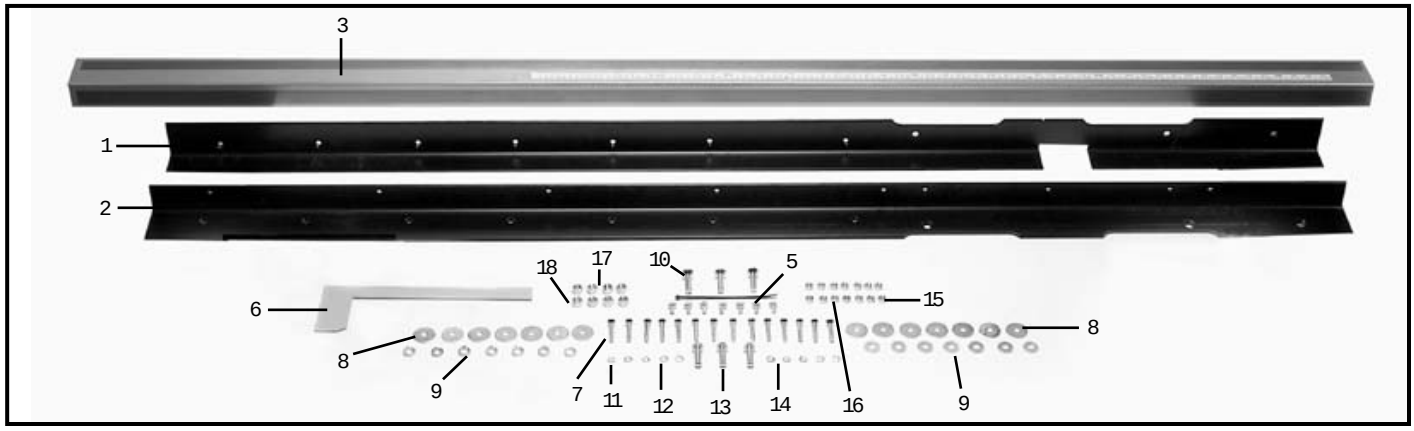

Fig. 3

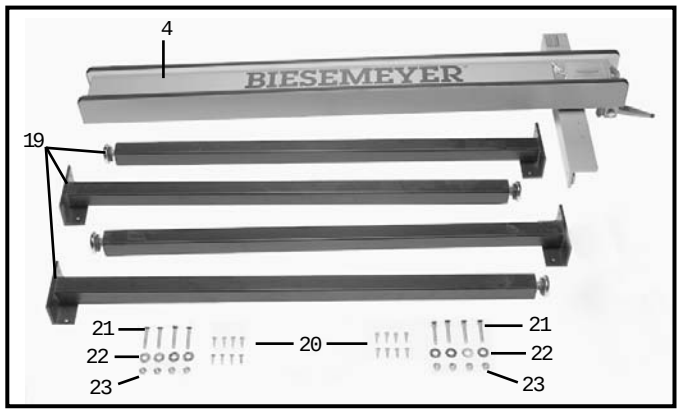

Fig. 4

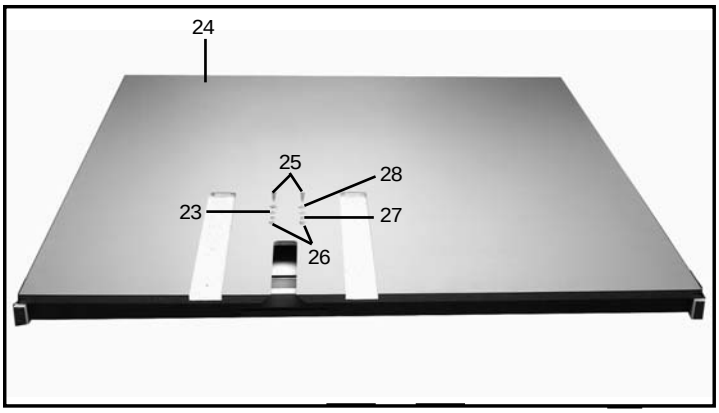

Fig. 5

BIESEMEYER FENCE SYSTEM

NOTE: A common hardware package is used for several different models, therefore you may have leftover hardware.

1 - Rear Rail
2 - Front Rail
3 - Guide Tube
4 - T-Square® Fence Assembly
5 - Cable Strap
6 - Template for aligning front rail to saw table

for fastening front and rear rails to right extension table
7 - 1½" long flat head Phillips screws (12)
8 - 1¼" O.D. Flat Washers (12)
9 - ¼-20 hex nuts (12)

for fastening rear rail to saw table
10 - ⅜-24 x 1¼" long hex head cap screws (2)
11 - ⅞" O.D. flat washers (2)
12 - Lock washers (2)

for fastening front rail to saw table
13 - ⅜-16 x 1¼" long flat head Phillips screws (2)
14 - ⅞" O.D. flat washers (2)
15 - Lock washers (2)
16 - ⅜-16 hex nuts (2)

for fastening guide tube to front rail
17 - ½ long hex screws (9)
18 - Lock washers (9)

leg hardware
19 - Legs (4)
20 - ⅝" long wood screws #8 (16)
21 - ¼-20 x 1½" long flat head phillips screws (8)
22 - ¼" flat washers (8)
23 - ¼-20 hex nuts (8)

rear extension table
24 Table board
25 10-32 hex head screw (2)
26 10-32 nut (2)
27 Flat washer (4)
28 Lock washer (2)

ASSEMBLY INSTRUCTIONS

WARNING: FOR YOUR OWN SAFETY, DO NOT CONNECT THE SAW TO THE POWER SOURCE UNTIL THE SAW IS COMPLETELY ASSEMBLED AND YOU HAVE READ AND UNDERSTOOD THE ENTIRE OWNER S MANUAL.

ASSEMBLING BLADE TILTING MECHANISM HANDLE

1. Install fiber washer (A) Fig. 6, on the blade tilting mechanism shaft (B). Install key (C), into shaft keyway.

2. Install handwheel (D) onto shaft (B) Fig. 6. Make sure the groove (E), in the handwheel lines up with the key (C).

3. Install lock knob (F) Fig. 7, into threaded end of the shaft (B). Hand-tighten lock knob at this time.

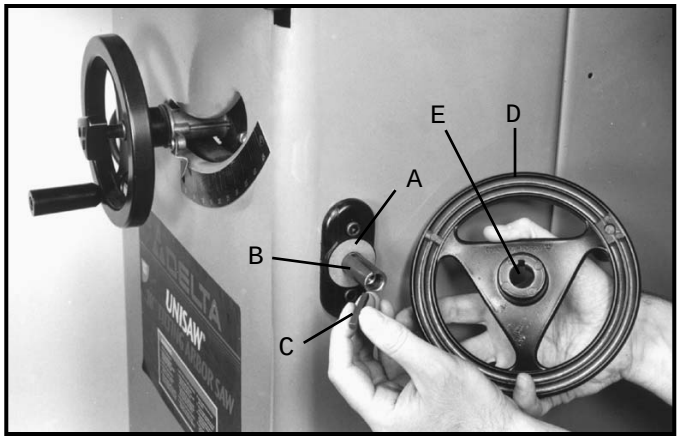

Fig. 6

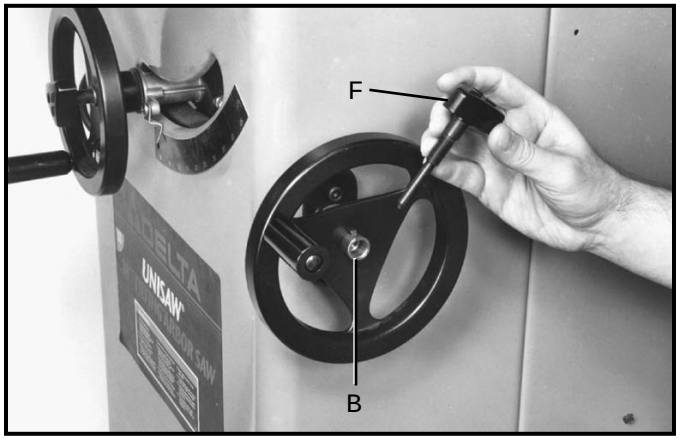

Fig. 7

ASSEMBLING EXTENSION WINGS

Assemble the extension wings (A) Fig. 8 and Fig. 10, to the saw table using the six 5/8"-24x1 1/4" hex head screws (B) and washers supplied. Use a straight edge (C) Fig. 9, to make sure the extension wings (A) are level with the saw table before tightening the screws (B) Fig. 8 and Fig. 10. NOTE: When assembling the left extension wing, do not install the left front screw and washer at this time, it will be installed when assembling the on/off switch.

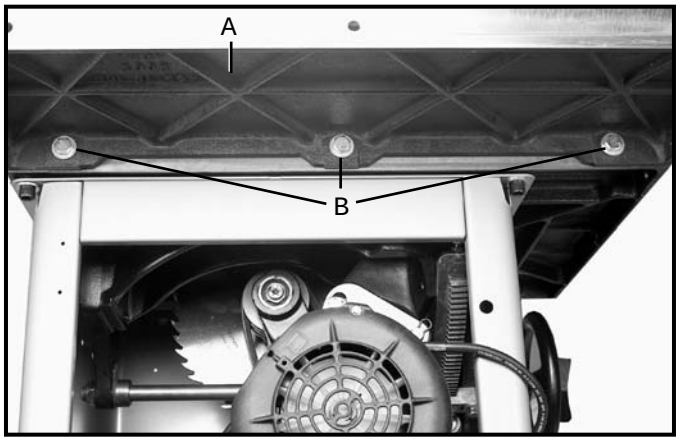

Fig. 8

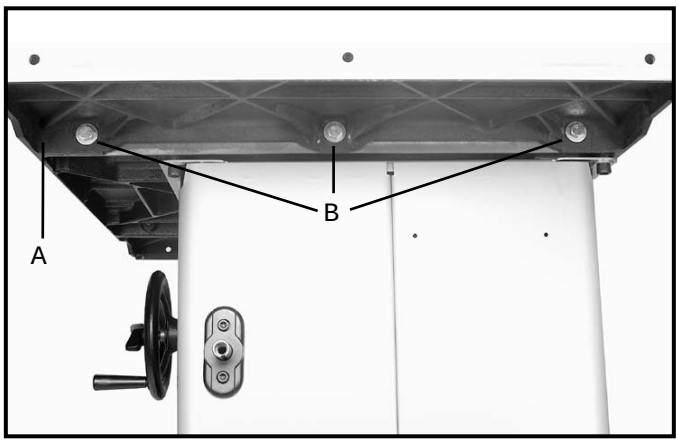

Fig. 10

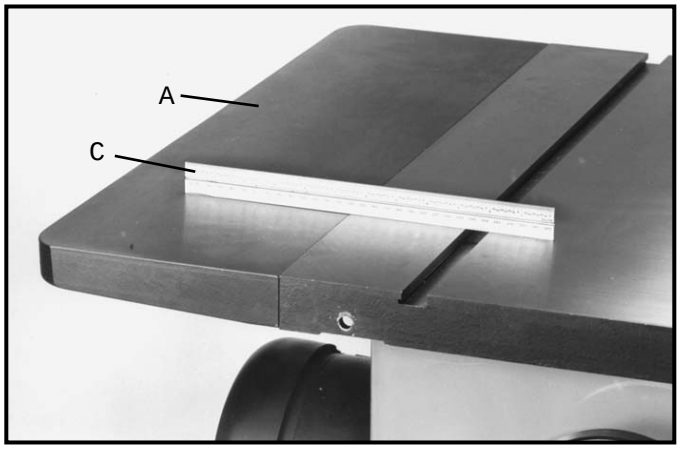

Fig. 9

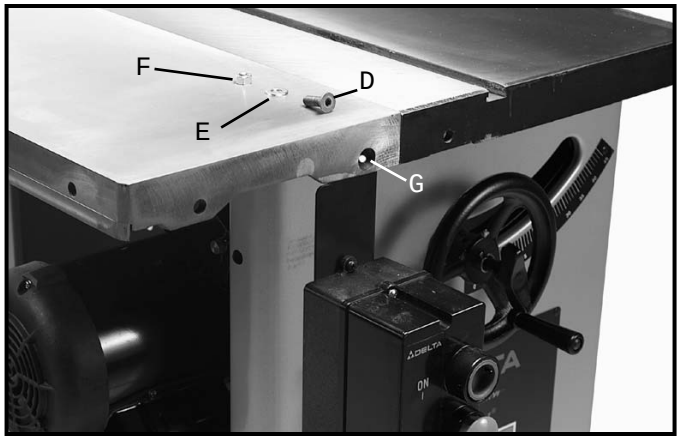

Fig. 11

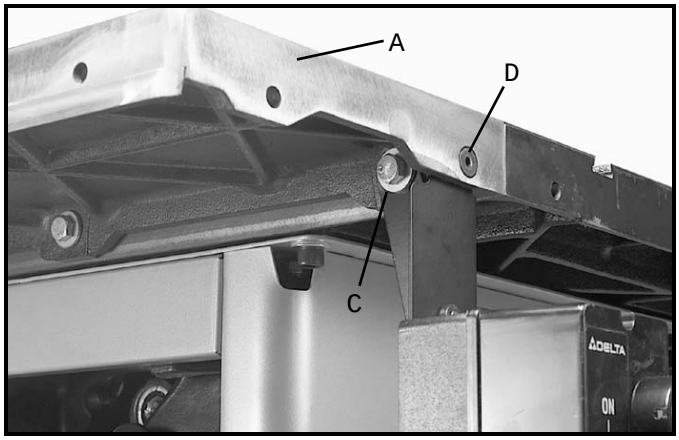

Fig. 12

ASSEMBLING ON/OFF SWITCH

1. Loosely assemble switch and switch bracket (A) Fig. 12, to the inside front lip of the left extension wing with hex flat head screw (D), flat washer (E), and hex nut (F) through hole (G) Fig. 11.

2. Attach the side of switch bracket (A) Fig. 12, to the inside of extension wing at the front of the saw using the 5/8"-24x 1 1/4" screw and flat washer.

3. Tighten screws (C) and (D), Fig. 12, securely.

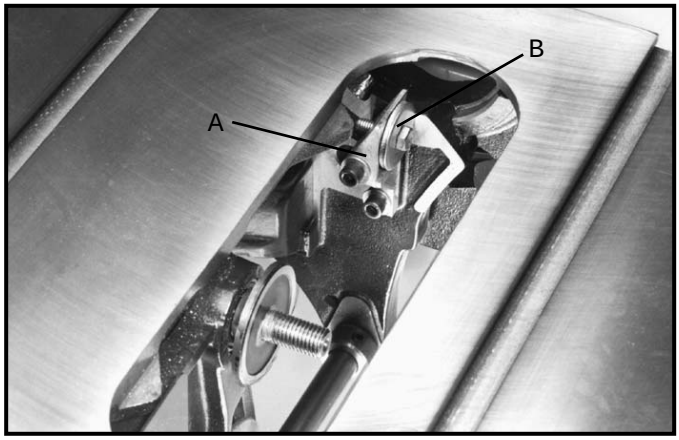

Fig. 13

ASSEMBLING BLADE GUARD AND SPLITTER ASSEMBLY

1. MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

2. Remove the table insert and saw blade from the machine by following instructions under section REMOVING SAW BLADE.

3. The inside splitter mounting bracket (A) Fig. 13, is assembled to the inside of the saw and aligned at the factory. To check the alignment of the bracket (A) to the inside arbor flange, remove screw and splitter fastener plate (B) Fig. 13.

4. Using a straight edge (C) Fig. 14, check to see if the splitter bracket (A) is aligned with the inside blade flange (D). Check both the top and bottom of bracket (A) with top and bottom of flange (D).

5. If an adjustment is necessary, loosen two screws (F) Fig. 15, and adjust splitter bracket (A) until it is aligned with the blade flange; tighten two screws (F). Loosely reassemble screw and plate removed in STEP 3.

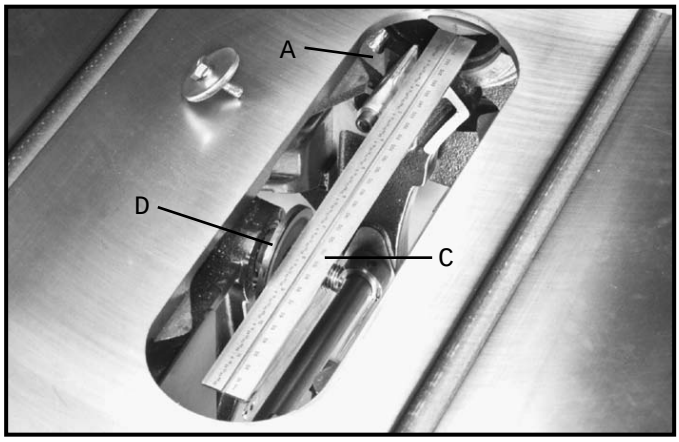

Fig. 14

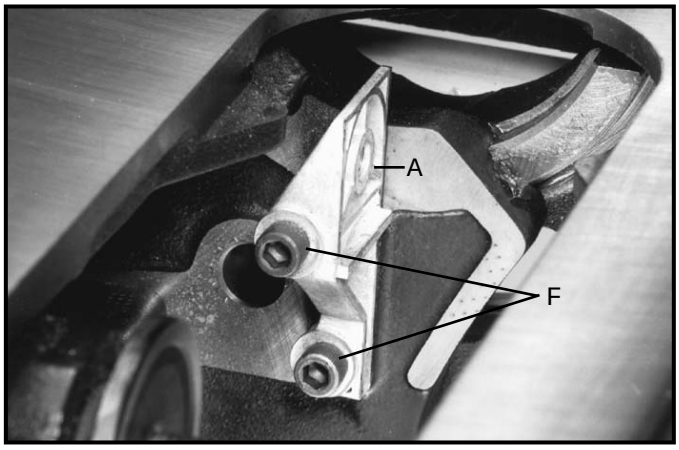

Fig. 15

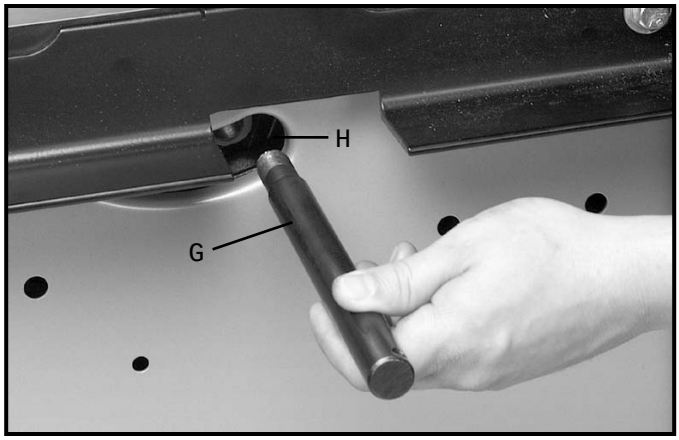

Fig. 16

Fig. 17

6. Insert threaded end of support rod (G) Fig. 16, through slot in back of saw and through hole (H) Fig. 16, in rear trunnion. Fasten support rod (G) Fig. 16, to trunnion using star washer and nut (J) Fig. 17. NOTE: Thread nut (J) onto threaded end of support rod as far as possible by hand. Using a wrench to hold nut (J) Fig. 17, tighten rod (G) Fig. 18, using a small screwdriver (K) or similar device through hole in end of rod (G) as shown.

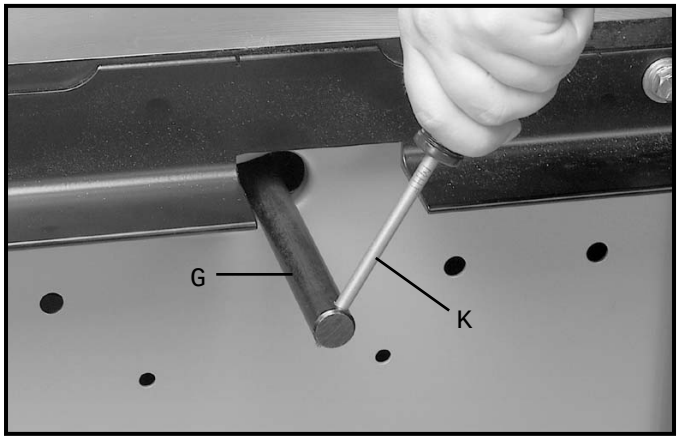

Fig. 18

7. Assemble lower bracket (L) Fig. 19, to rod (G) and snug up with 2 one inch-long hex head screws (S) and lockwashers, from underneath bracket (L).

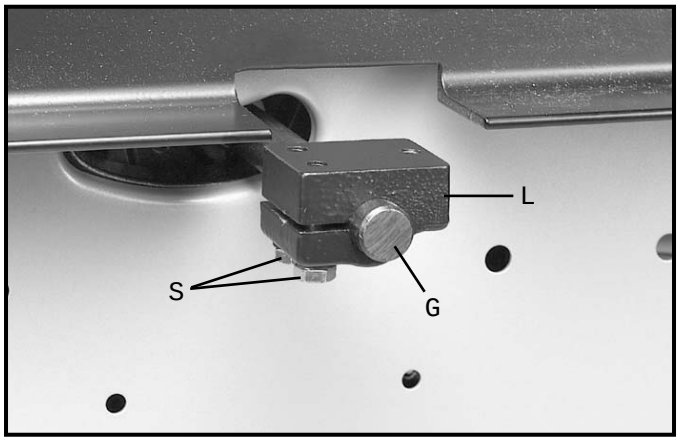

Fig. 19

8. Assemble splitter bracket (M) Fig. 20, to lower bracket (L), using one inch-long hex head screw (N), lockwasher and flat washer. Do not fully tighten screw (N) at this time.

9. Fasten splitter and guard assembly (P) Fig. 21, to bracket (M) using one inch-long hex head screw (V) and flat washer.

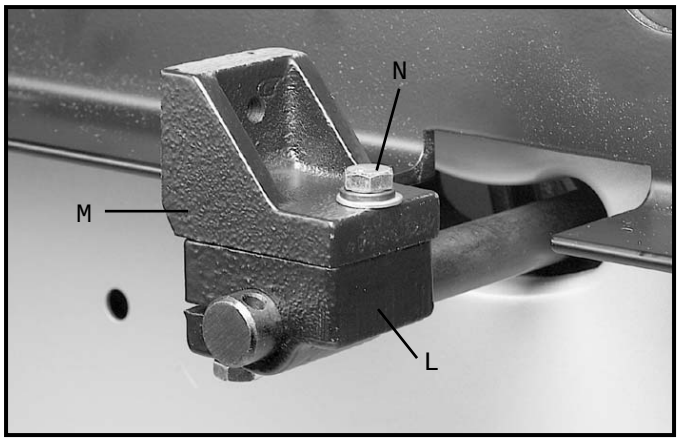

Fig. 20

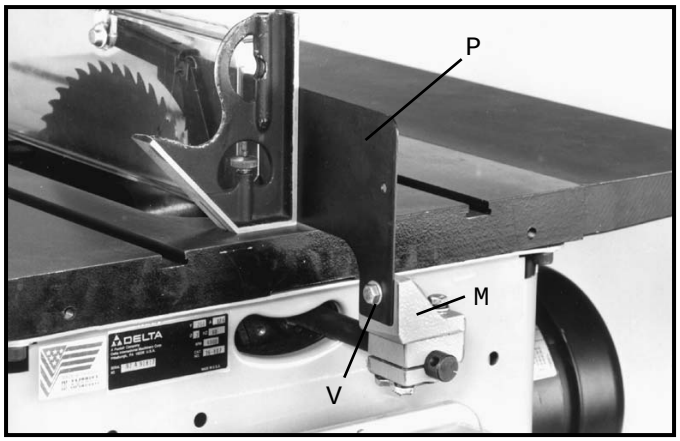

Fig. 21

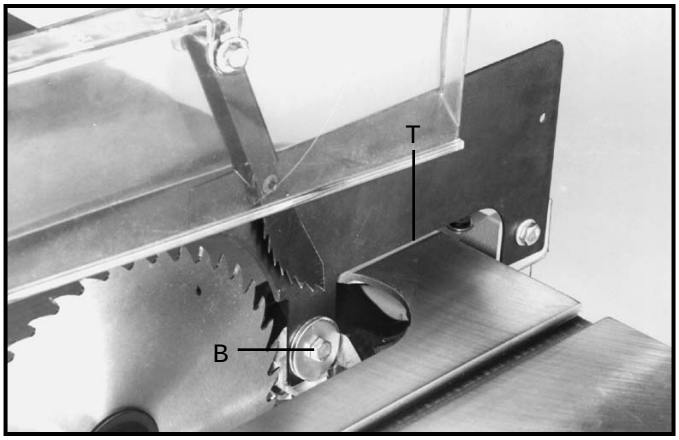

Fig. 22

10. Assemble splitter (P) Fig. 22, inside the splitter mounting bracket as shown. Push splitter (P) down as far as possible, making certain bottom edge (T) of splitter (P) is parallel with table surface, and tighten screw (B).

11. Reassemble the saw blade (U) Fig. 22.

12. Using a straight edge (A) Fig. 23, and square (B) Fig. 24, align splitter (P) with the saw blade and table by moving brackets (M) and (L) until the splitter (P) is in perfect alignment with the blade and square with the table. After alignment is made, tighten hex head screw (N), and two screws (S) Fig. 24.

13. IMPORTANT: For certain cutting operations such as dadoing and moulding where you are not cutting completely through the workpiece, the blade guard and splitter assembly cannot be used. Loosen screws (B) and (V) Fig. 25. Lift up and swing blade guard and splitter assembly to the rear of the saw. CAUTION: Always return the blade guard and splitter assembly to its proper operating position for normal thru-sawing operations.

BIESMEYER FENCE ASSEMBLY

ASSEMBLING GUIDE RAILS

1. Assemble the front rail (A) Fig. 26, to front of saw table using the two $^{3}/_{8}$-16 x $1^{1}/_{4}$" flat head Phillips screws (B), $^{7}/_{8}$" flat washers, lockwashers and $^{3}/_{8}$-16 hex nuts supplied. Screws (B) are inserted through the two holes in the front rail, as shown in Fig. 26, and through the two through holes in the front of the saw table and fastened to the table with the flat washers, lockwashers and hex nuts. IMPORTANT: Do not completely tighten front rail mounting hardware at this time.

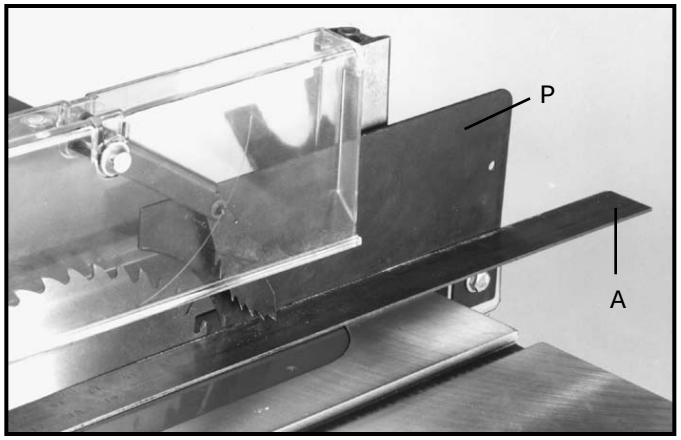

Fig. 23

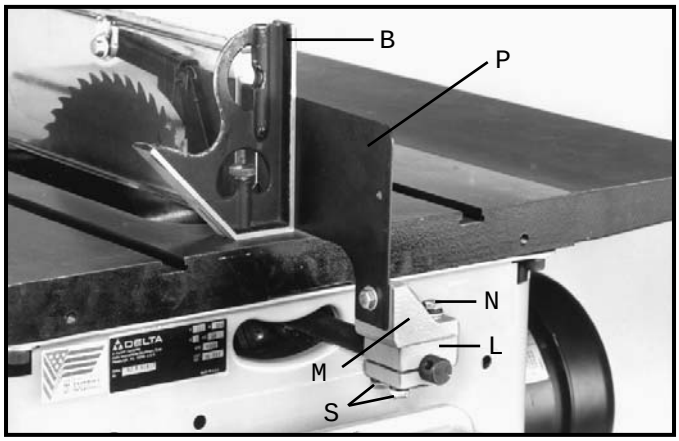

Fig. 24

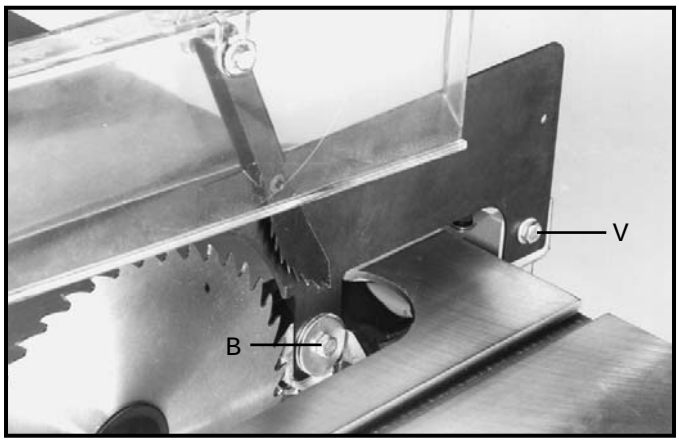

Fig. 25

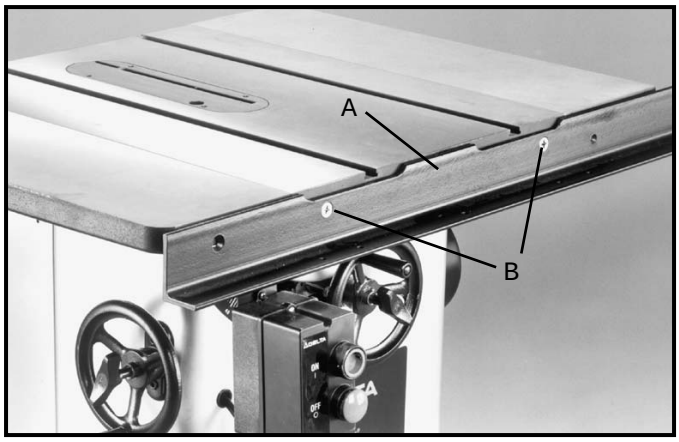

Fig. 26

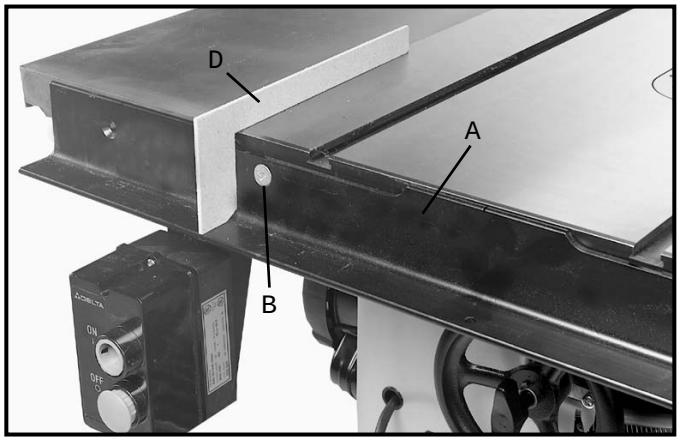

Fig. 27

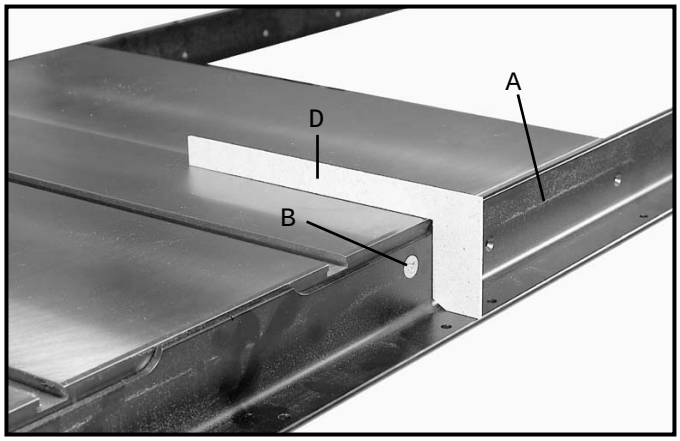

Fig. 28

2. Using template (D) Figures 27 and 28, to check and adjust front rail at both ends of the saw table as shown, to make sure rail (A) is parallel with table surface and tighten rail mounting hardware (B). IMPORTANT: Template (D) must be on the saw table when checking, not on extension wing.

3. Assemble rear rail (E) Fig. 29, to rear of saw table using the two 3/8-24 x 1 1/4" hex head screws (F), 7/8" O.D. flat washers, and lockwashers as shown. NOTE: When mounting, the two screws (F) are threaded into the threaded holes in the saw table, as shown.

4. Make certain top edge of rail (E) Fig. 29 is below table surface and that top edge of cut-outs (G) are below miter gage slots before tightening screws (F).

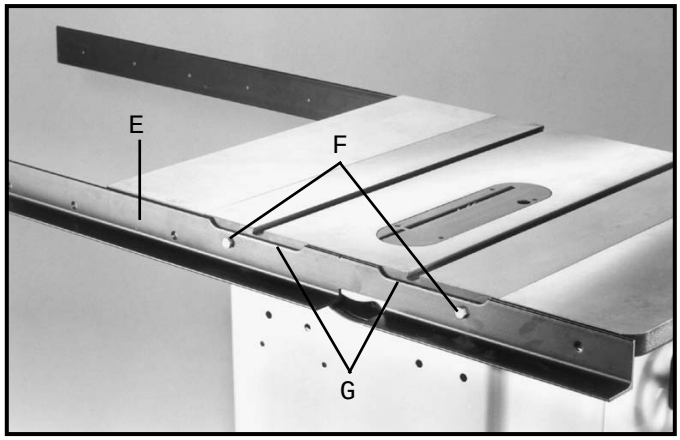

Fig. 29

ASSEMBLING TABLE LEGS TO EXTENSION TABLE

1. Position the two legs (H) Fig. 30, at the two far corners of the inside of one end of the extension table, as shown, and mark the position of the eight holes to be drilled into the bottom of the table. IMPORTANT: If your saw will be used with a mobile base underneath the saw base and table legs, the position of the legs may have to be changed to fit onto the mobile base. Remove the two legs (H) and using a 1/16" drill bit, drill the eight holes 1/2" deep. Replace the two legs and fasten to the bottom of the table using the eight 3/4" wood screws (I) supplied.

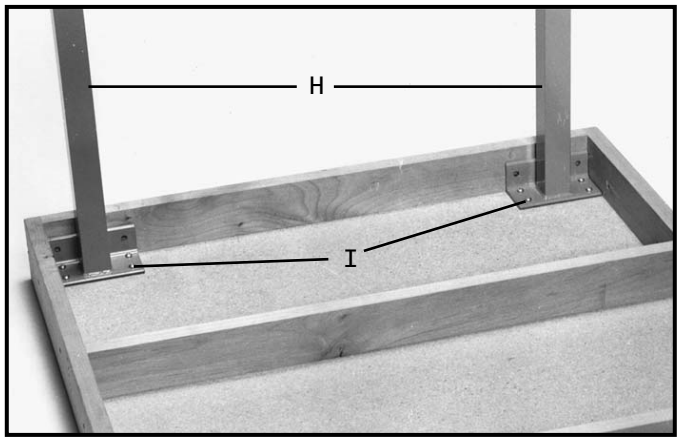

Fig. 30

2. Figure 31 illustrates one of the legs (H) fastened to the bottom of the extension table with the four wood screws (I). Using a 1/4" drill bit, drill two through holes through the end piece (J) of the table, measuring the holes from the outside frame of the table. The holes are to be drilled 1 3/4" from the top (laminate side), and 1 3/8" and 4 3/8" from the side.

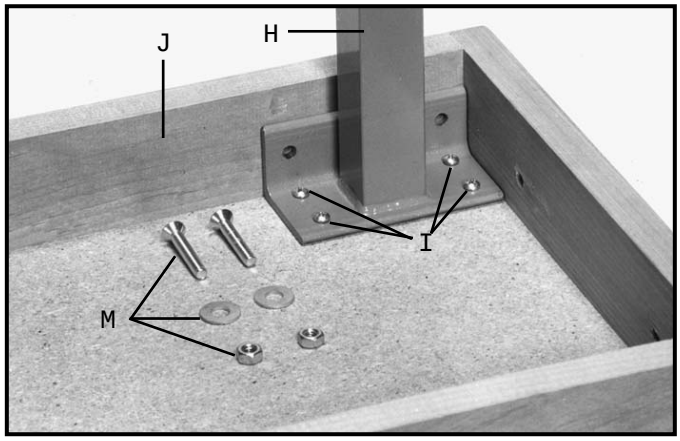

Fig. 31

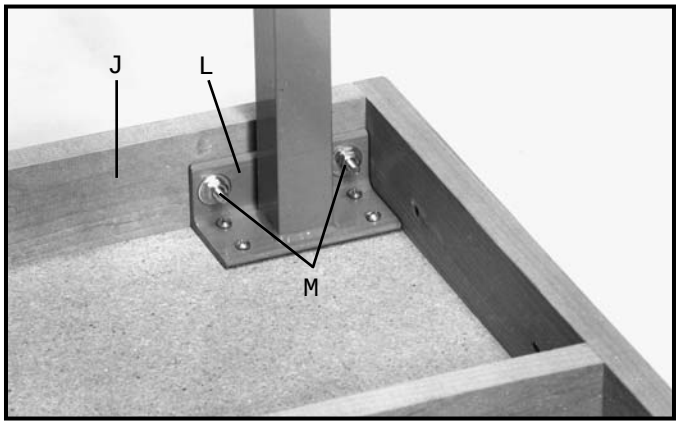

Fig. 32

3. Fasten the leg bracket (L) Fig. 32, to the end piece (J) of the table using the two 1½" flat head Phillips screws, flat washers and hex nuts (M) Figs. 31 and 32. Fasten the remaining leg to the extension table in the same manner.

ASSEMBLING EXTENSION TABLE TO FRONT AND REAR RAILS

1. Place table assembly (N) Fig. 34, in position between the two rails, as shown. Make sure end of table (N) is flush against extension wing (P). Using a straight edge make sure table (N) is in the same plane and level with saw table (P). Lightly tap table up or down and adjust leveling screws (R) Fig. 33, in bottom of legs to accomplish this. When the table (N) Fig. 34 is level and in the same plane with saw table (P), drill ¼" through holes (S) Fig. 34 through the front and rear holes in the guide rail closest to the extension wing. Fasten both front and rear rail to table using the 1½" flat head Phillips screws, flat washers, and hex nuts. Using a level make sure table (N) is in the same plane and level with saw table (P). Drill ¼" through holes (S) Fig. 34 through the front and rear holes remaining in the guide rail.

2. After the holes have been drilled in the edge of the front and rear extension table board, fasten both front and rear rail to table using the 1½" flat head Phillips screws, flat washers, and hex nuts (M) Fig. 31.

ASSEMBLING GUIDE TUBE TO FRONT RAIL

Lay the guide tube (B) on the saw table as shown in Fig. 35, and line up the threaded holes on bottom of guide tube (B) with the through holes (D) on the front rail (A). Fasten the guide tube to the rail using ½" hex screws and lockwashers in all of the holes.

REAR SUPPORT TABLE MOUNTING INSTRUCTIONS

1. Position the two legs (H) Fig. 36, at the two far corners of the inside of one end of the extension table, as shown, and mark the position of the eight holes to be drilled into the bottom of the table. Remove the two legs (H) and using a 1/16" drill bit, drill the eight holes ½" deep. Replace the two legs and fasten to the bottom of the table using the eight

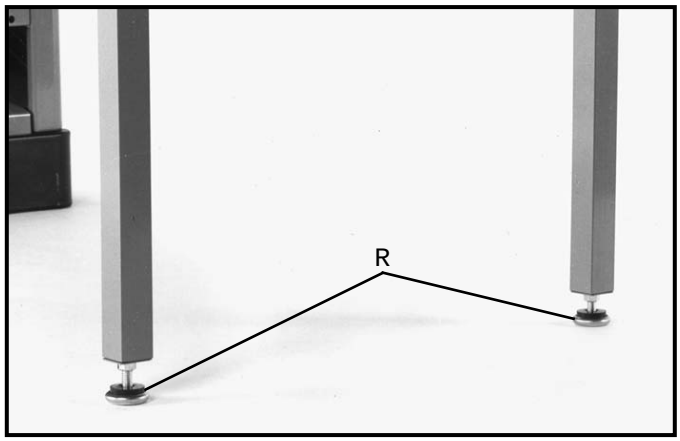

Fig. 33

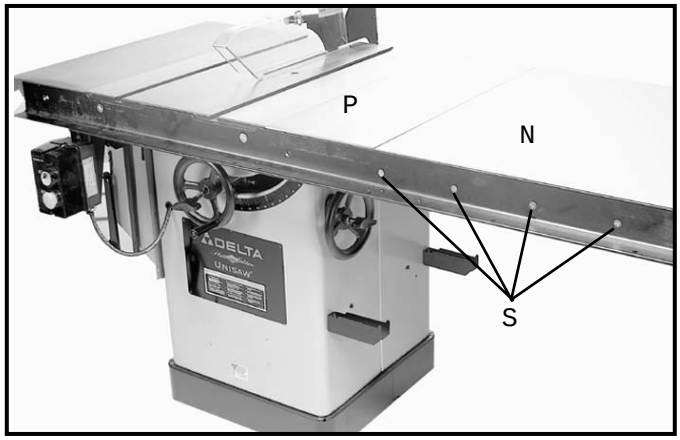

Fig. 34

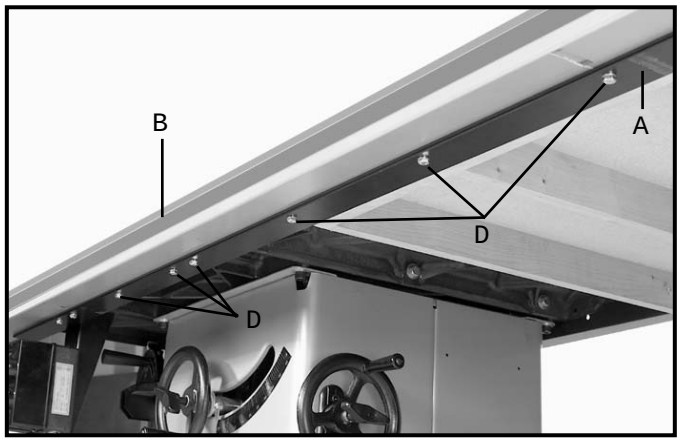

Fig. 35

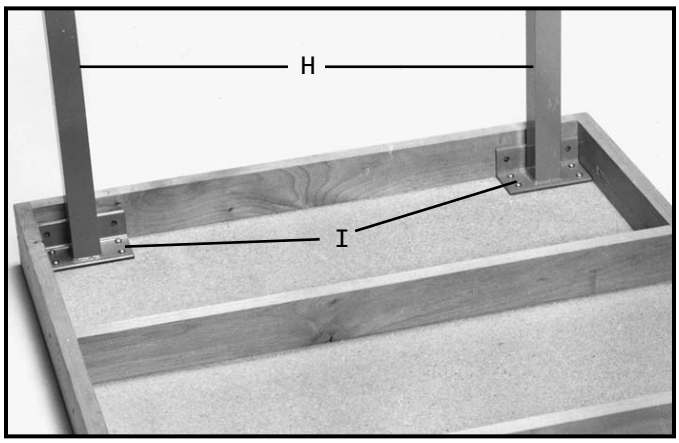

Fig. 36

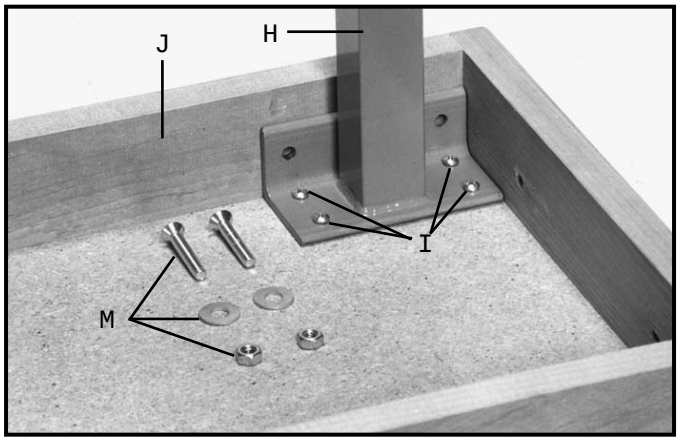

Fig. 37

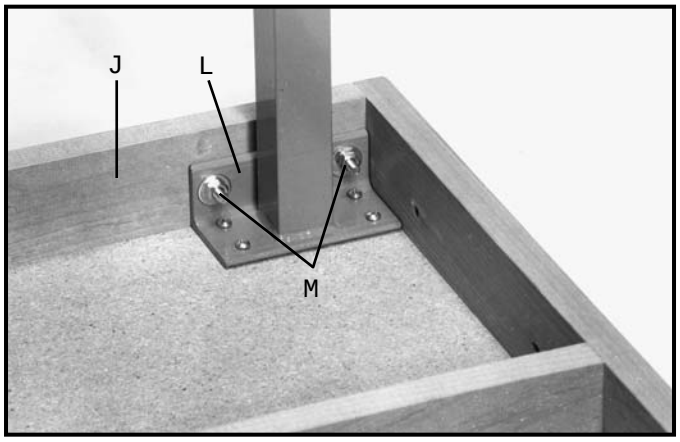

Fig. 38

3/4" wood screws (I) supplied.

2. Figure 37 illustrates one of the legs (H) fastened to the bottom of the extension table with the four wood screws (I). Using a 1/4" drill bit, drill two through holes through the end piece (J) of the table, measuring the holes from the outside frame of the table. The holes are to be drilled 3/4" from the bottom, and 1 1/4" and 4 1/4" from the side.

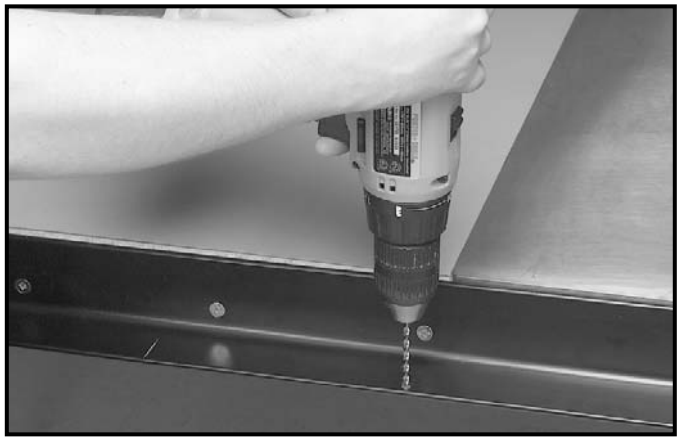

Fig. 39

3. Fasten the leg bracket (L) Fig. 38, to the end piece (J) of the table using the two 1 1/2" flat head Phillips screws, flat washers and hex nuts (M) Figs. 37 and 38. Fasten the remaining leg to the extension table in the same manner.

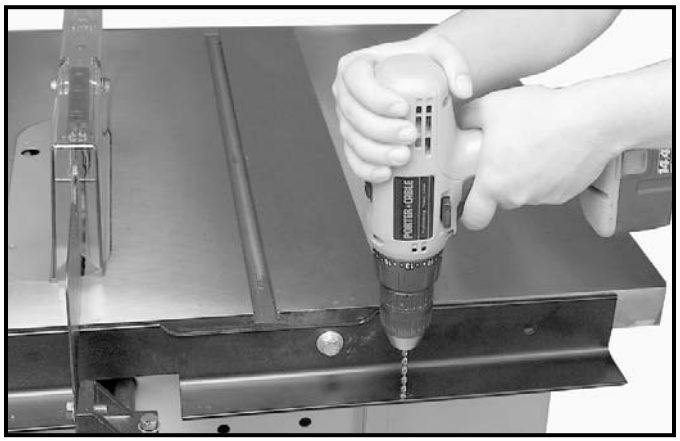

Fig. 40

4. Position the table onto the rear rail, making sure there is clearance for the miter gage slots and blade guard, and mark the spots to be drilled in the rear rail to attach the rear support table. NOTE: DRILL THE HOLES 1/4" FROM THE EDGE OF THE RAIL, AND 7 1/2" FROM EACH EDGE OF THE REAR TABLE SO THAT THERE WILL BE PROPER CLEARANCE FOR ATTACHING THE HARDWARE.

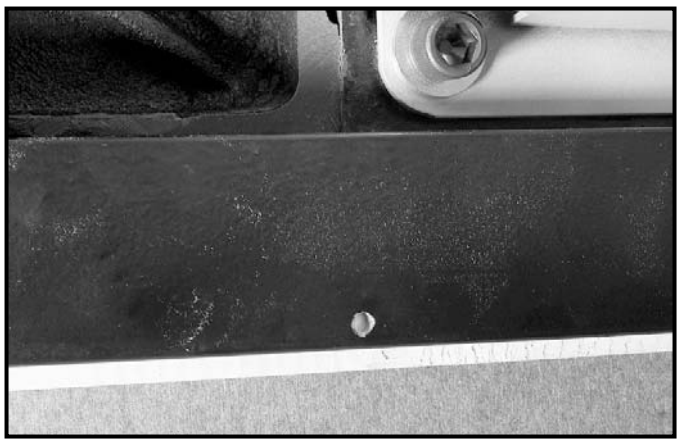

Fig. 41

5. Use a 3/16" drill bit to drill the two holes in the rear rail, approximately 7 1/2" from each corner of the table board, Fig. 39 & 40.

6. After the holes are drilled in the rear rail, position the

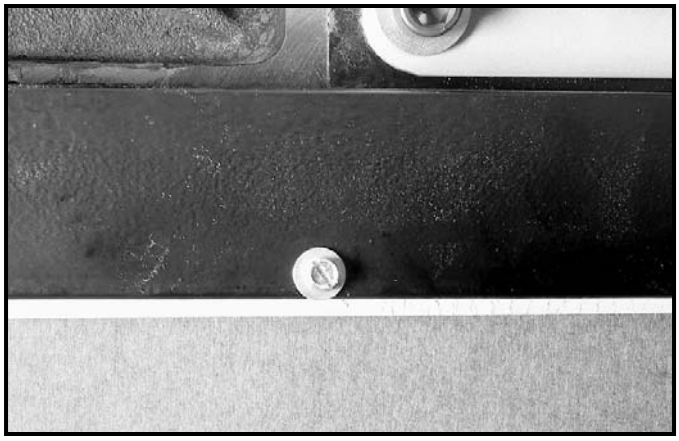

Fig. 42

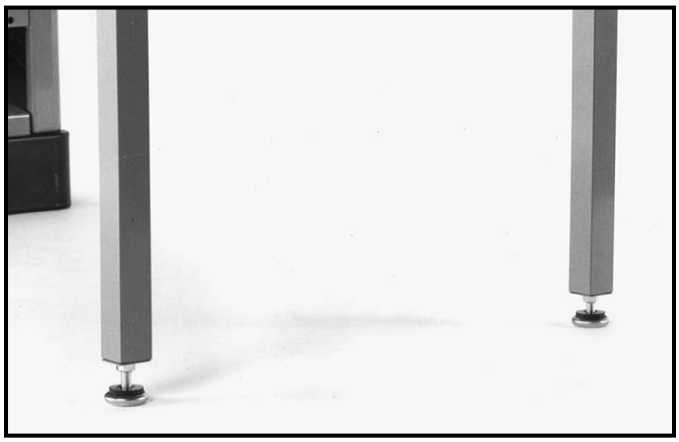

Fig. 43

table board back onto the rear rail, and drill through the holes in the rear rail through the table board, Fig. 41.

7. Fasten the rear table board to the rear rail with two 10-32 screws, lockwashers, flat washers, and nuts, Fig. 42.

8. Level the table by adjusting the table legs in the rear table board, Fig. 43.

FASTENING MOTOR CORD TO SAW FRAME

1. IMPORTANT: Turn the blade tilting handwheel counterclockwise as far as it will go until the saw blade is in the 45 degree position.

2. IMPORTANT: Turn the blade raising and lowering handwheel counterclockwise as far as it will go.

3. Fasten motor cord (A) Fig. 44 to the saw frame cross member (B), using the cable tie (C) supplied with the saw. CAUTION: Before tightening the cable tie, make certain that cord (A) is free of any interference from the motor or saw blade at all possible positions of the motor.

After the cable tie is tightened, cut off excess tail of cable tie (C) Fig. 44.

Fig. 44

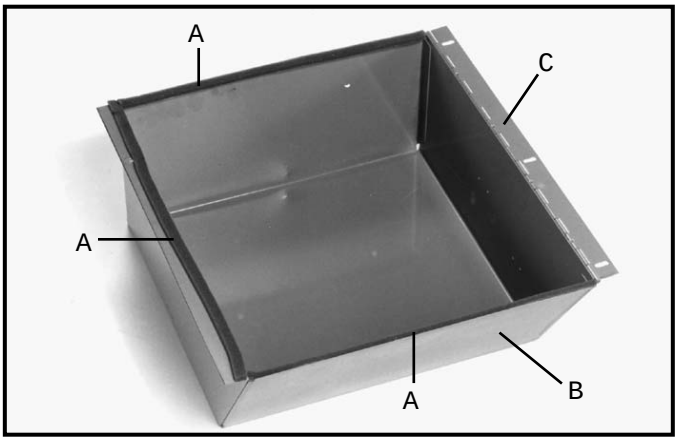

Fig. 45

ASSEMBLING MOTOR COVER

1. Measure the three sides of the motor cover, (the sides without the hinges), and cut gasket to fit each side. Remove the protective paper from the gasket material supplied with the machine and apply gasket (A) Fig. 45, to three sides of the back of the motor cover (B). NOTE: Do not apply gasket to the hinged side (C) of the motor cover (B) Fig. 45.

2. Assemble hinged side (C) Fig. 46, of motor cover (B)

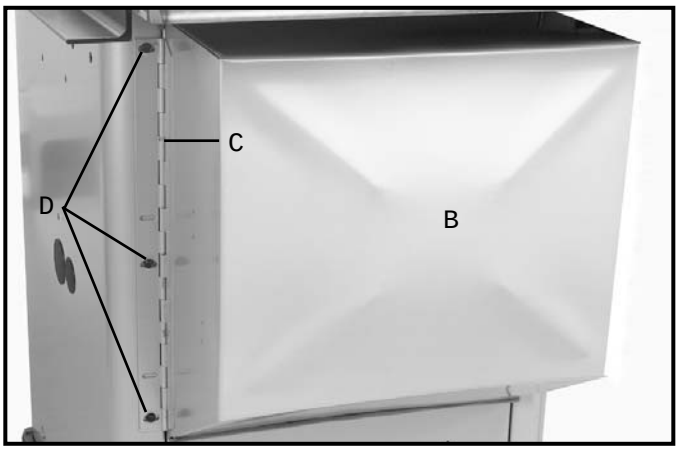

Fig. 46

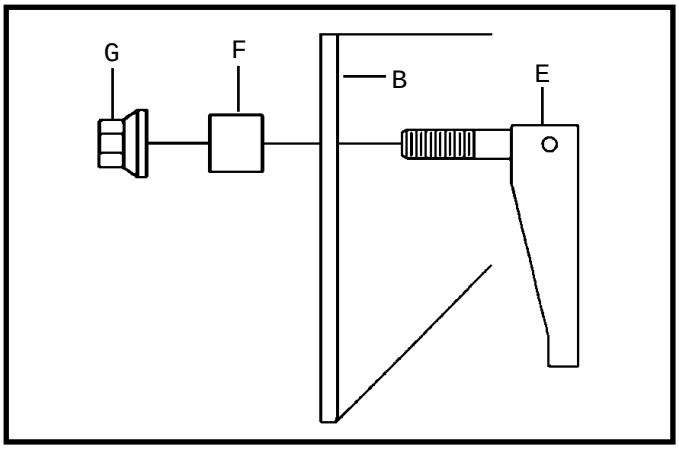

Fig. 47

to the left rear of the saw cabinet using three ½" sheet metal screws (D).

3. Insert locking lever (E) Fig. 47, through the hole in the right edge of motor cover (B). Assemble spacer (F) over threads of lever (E), and fasten lever to motor cover with lock nut (G) Fig. 47.

4. With locking lever (E) in the raised position, as shown in Fig. 48, swing the free end of motor cover (B) toward the front of the cabinet until end (H) of locking lever fully enters and engages with the pre-drilled hole (J) in the cabinet.

5. While holding motor cover against cabinet, push down on lever (E) Fig. 49, to lock motor cover (B) in position on the saw cabinet.

6. To open motor cover (B) Fig. 49, pull up on lever (E), and swing motor cover outward.

ASSEMBLING MITER GAGE AND WRENCH HOLDER BRACKETS

Assemble the miter gage holder bracket (A) Fig. 50, and wrench holder bracket (B) to the four thru-holes on the front of the motor cover using the four ½" sheet metal screws supplied, two of which are shown at (C).

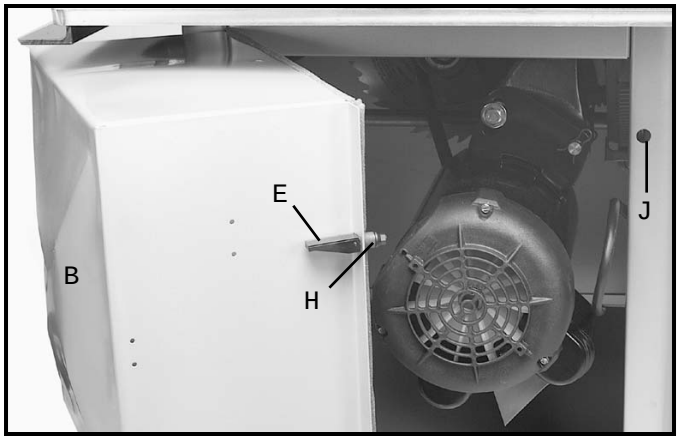

Fig. 48

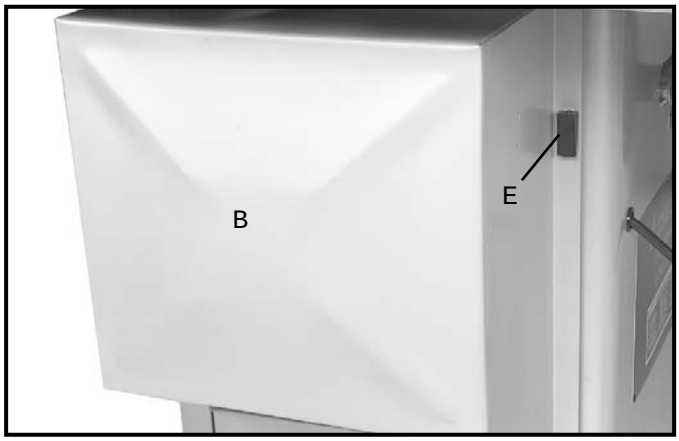

Fig. 49

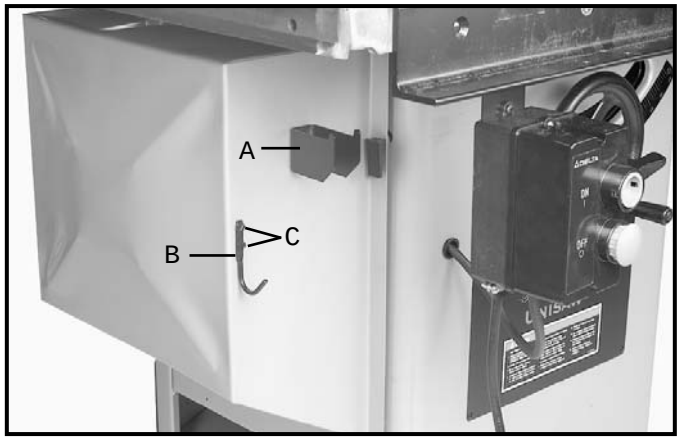

Fig. 50

Fig. 51

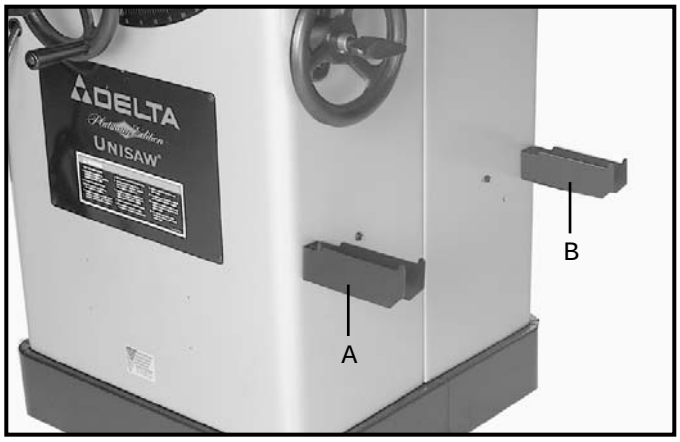

Fig. 52

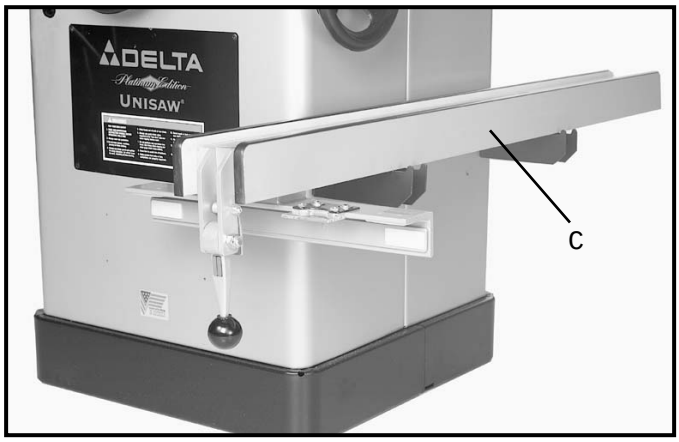

Fig. 53

Fig. 51, illustrates the miter gage and wrenches stored on the two holder brackets.

ASSEMBLING RIP FENCE HOLDER BRACKETS

Assemble the rip fence holder brackets (A) and (B) Fig. 52, to the four holes located in the right hand side of the saw cabinet using four ½" sheet metal screws supplied. Figure 53 illustrates the Biesemeyer fence (C), (when not in use), positioned on the two holder brackets.

Fig. 54

ATTACHING LITERATURE HOLDER TO SAW CABINET

A literature holder (A) Fig. 54, is supplied with your saw to provide storage and protection for the machine's instruction manual, parts list, etc., so they may be readily available for reference. Two push rivets (B) are supplied to attach the literature holder to the right side of the saw cabinet, as shown in Fig. 54.

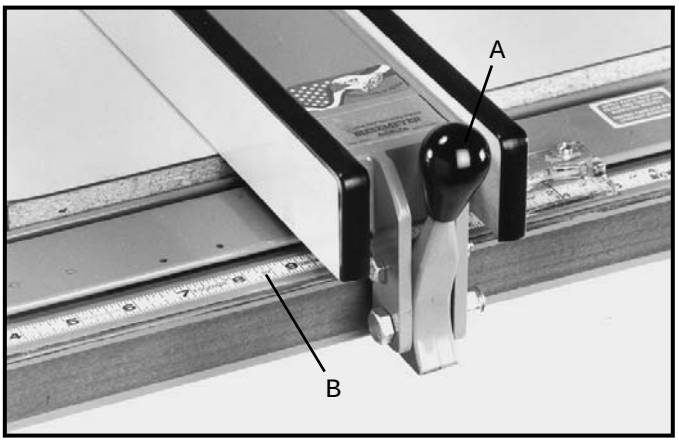

Fig. 55

FENCE OPERATION

IMPORTANT: Before operating fence, make sure the fence is adjusted parallel to the miter gage slot, as explained later on in this manual.

1. To place the fence on the guide rail, lift up clamp (A) Fig. 55, and place the fence over the rail and gently push fence onto rail (B) Fig. 55.

2. To move the fence along the guide rail, simply lift up clamp lever (A) as shown in Fig. 55, slide fence to desired position on rail, and push down on clamp lever (A) Fig. 56,

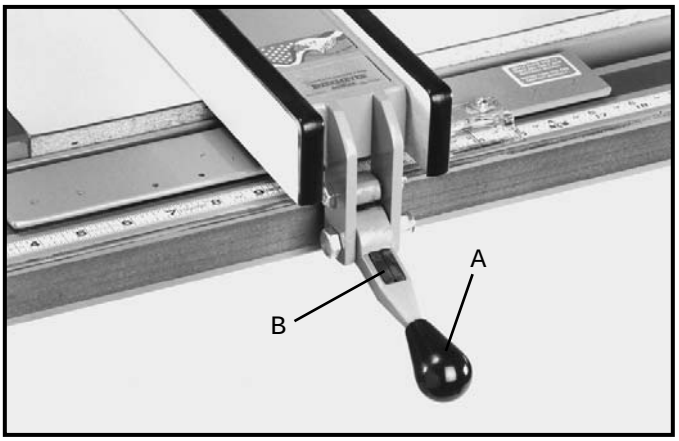

Fig. 56

to lock fence in position. NOTE: A magnet (B) Fig. 56, is provided to hold clamp handle (A) in the up position when moving the fence.

3. The distance the fence is positioned away from the blade is indicated by the witness line (C) Fig. 57, located on the cursor (D). If it is necessary to adjust the cursor (D), make a test cut with the fence locked in position. Measure the width of the finished cut and adjust the cursor (D) by loosening the two screws (E), adjusting the cursor (D) until the witness line (C) is aligned with the same marking on the scale as the finished cut. Then tighten the two screws (E).

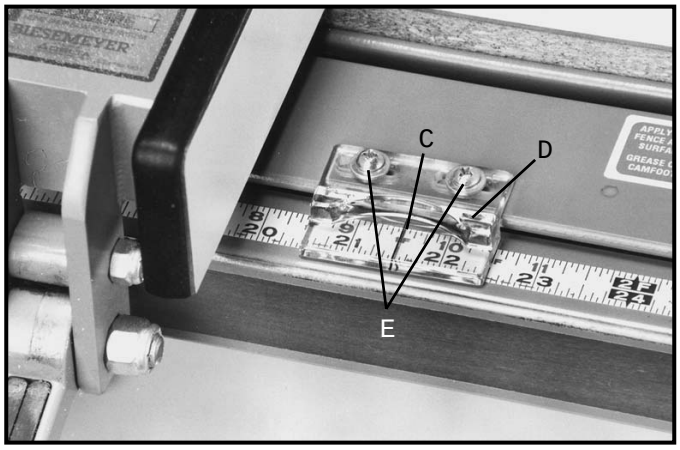

Fig. 57

FENCE LUBRICATION

1. Apply paste wax to fence, and guide tube, sliding surfaces weekly.

2. Apply grease to cam lock (A) and cam foot (B) Fig. 58, monthly, to prevent wear.

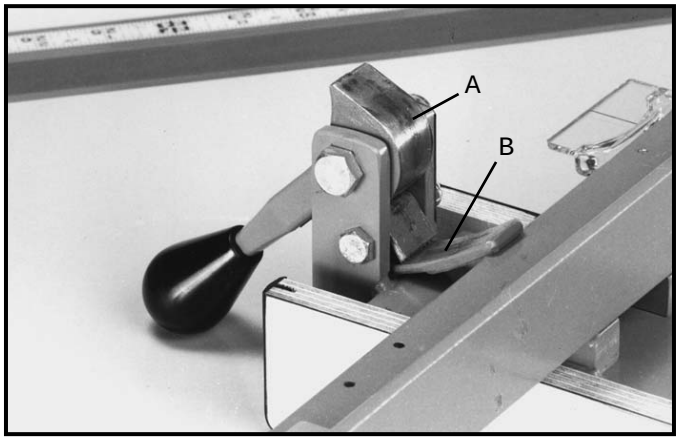

Fig. 58

ADJUSTING FENCE PARALLEL TO MITER GAGE SLOTS

The fence (A) Fig. 59, must be adjusted so it is parallel to the miter gage slots (B). To check and adjust, move fence (A) until the bottom edge of the fence is in line with the edge of one of the miter gage slots as shown in Fig. 59, and push down on the fence clamping lever (C). Check to see if the fence (A) is parallel to the miter gage slot, the entire length of the table. If an adjustment must be made, lift up fence locking lever (C) and raise fence up off the guide tube, as shown in Fig. 60. Slightly tighten or loosen one of the two adjusting screws (D) or (E) Fig. 60, using a 3/16" allen wrench (F), not supplied. Replace the fence on the guide tube and check again to see if the edge of the fence is parallel with the miter gage slot the entire length of the slot. Repeat this adjustment until you are sure the fence is parallel with the miter gage slot.

IMPORTANT: VERY LITTLE MOVEMENT OF

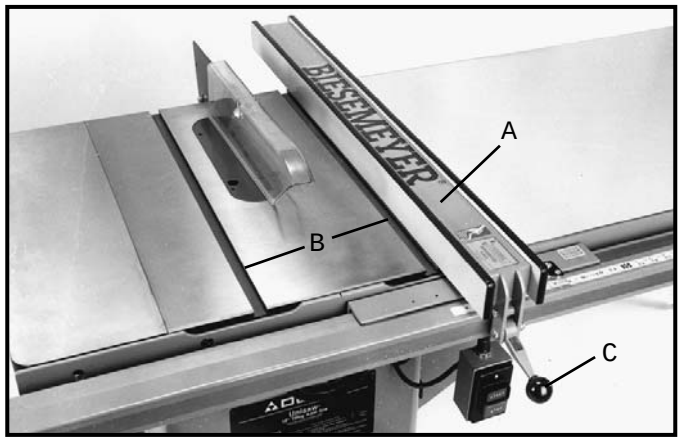

Fig. 59

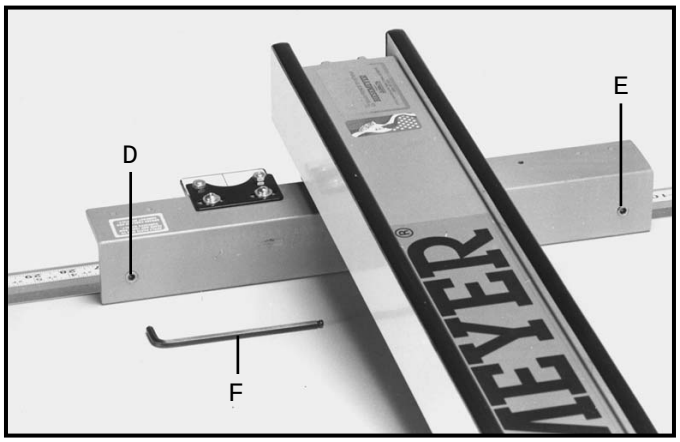

Fig. 60

SCREWS (D) AND (E) IS NECESSARY TO ADJUST THE

ADJUSTING CLAMPING ACTION OF FENCE LOCKING HANDLE

When the fence locking handle (A) is pushed to the down position, as shown in Fig. 61, the fence assembly (B) should be completely clamped to the guide tube (C). If the fence assembly (B) is not completely clamped to the guide tube (C) when the handle (A) is pushed down, as shown in Fig. 61, lift up handle (A) and raise fence assembly (B) up off the guide tube (C). Slightly tighten the two adjusting screws (D) and (E) Fig. 60, using the 3/16" allen wrench (F) (not supplied). When adjusting screws (D) and (E) Fig. 60. the screws should be tightened to an equal amount. Place fence on guide tube and recheck, adjust if necessarry.

IMPORTANT: AFTER ADJUSTING THE CLAMPING ACTION OF THE FENCE LOCKING HANDLE, CHECK TO SEE IF THE FENCE IS PARALLEL TO THE MITER GAGE SLOT AND ADJUST IF NECESSARY.

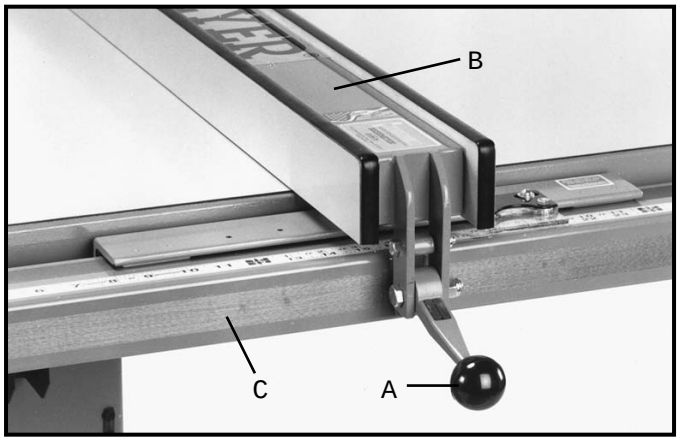

Fig. 61

ADJUSTING TABLE INSERT

Place a straight edge (B) across the table at both ends of the table insert as shown in Fig. 62. The table insert (A) should always be level with the table. If an adjustment is necessary, turn the adjusting screws (C), as needed. Four adjusting screws (C) are supplied.

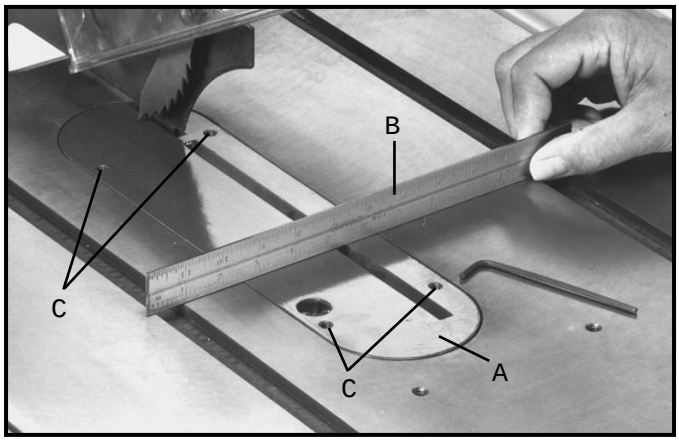

Fig. 62

CONNECTING SAW TO POWER SOURCE

GROUNDING INSTRUCTIONS

CAUTION: THIS TOOL MUST BE GROUNDED WHILE ELECTRIC SHOCK.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. The motor is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.

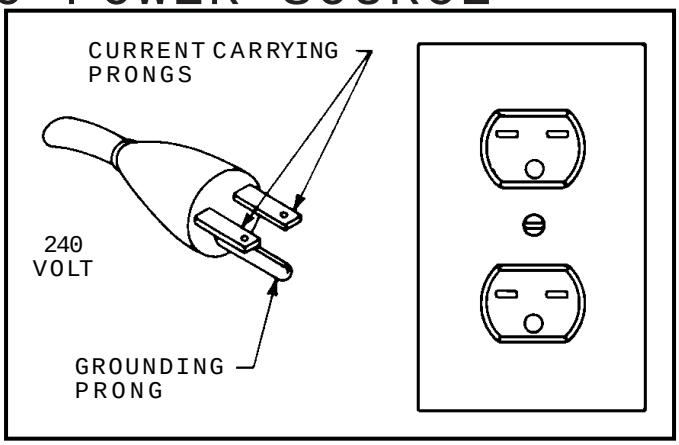

Fig. 63

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Repair or replace damaged or worn cord immediately.

SINGLE PHASE OPERATION

THREE HORSEPOWER MOTORS

The motor supplied with the Unisaw is single phase, 3 horsepower, and is designed to be operated from a 220-240 volt power system only.

The single phase motor is intended to be used on a circuit that has an electrical outlet and plug that looks like the one illustrated in Fig. 63. Make certain the tool is connected to an outlet having the same configuration as the plug (NEMA L-15R). No adapter is available, or should be used with the tool. CAUTION: IN ALL CASES, MAKE CERTAIN THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE, HAVE A CERTIFIED ELECTRICIAN CHECK THE RECEPTACLE.

If you desire to operate the tool with an extension cord, use a proper extension cord and make certain it is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Fig. 64, shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.

Total Length of cord in feet	Gage of extension cord to use
50	14 AW G
100	12 AW G
Over 100	Not recommended

Fig. 64

OPERATING CONTROLS AND ADJUSTMENTS

STARTING AND STOPPING THE SAW

1. To apply power to the machine, push ON button (A) Fig. 65.
2. To stop the machine, push OFF button (B).

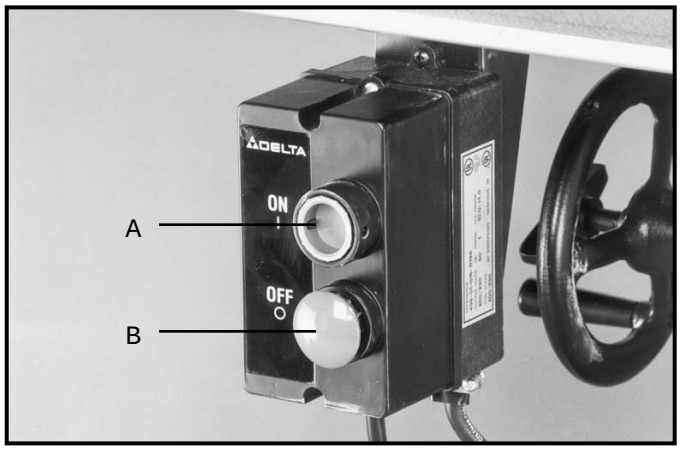

Fig. 65

LOCKING SWITCH IN THE OFF

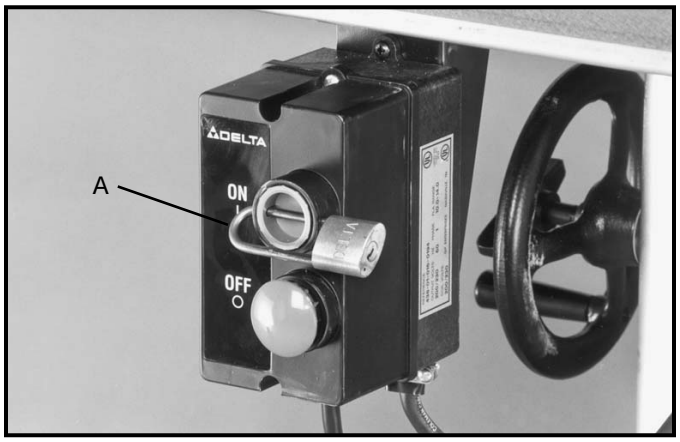

Fig. 66

POSITION

IMPORTANT: When the tool is not in use the switch should be locked in the OFF position using a padlock (A) Fig. 66, to prevent unauthorized use of the tool.

BLADE RAISING MECHANISM

The saw blade is raised and lowered with the front handwheel (A) Fig. 67. With the exception of hollow

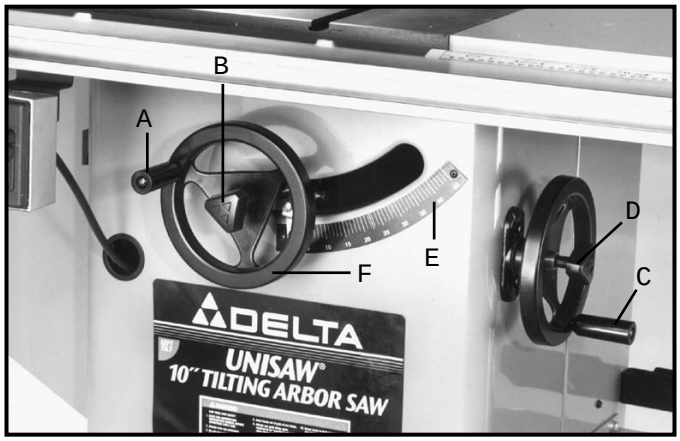

Fig. 67

ground blades, the blade should be raised 1/8" to 1/4" above the top surface of the material being cut. With hollow ground blades, the blade should be raised the maximum to provide greater clearance. To raise the saw blade, loosen lock knob (B) Fig. 67, and turn the handwheel (A), clockwise. To lower the saw blade, turn handwheel (A) counterclockwise.

The saw blade is locked at any height by turning the lock knob (B) Fig. 67, clockwise. Due to the wedge action of this locking device, only a small amount of force is required to lock the blade raising mechanism securely. Any added force merely puts unnecessary strain on the locking device.

Limit stops for raising or lowering are permanently built into the mechanism and need no further adjustment.

BLADE TILTING MECHANISM

The blade tilting mechanism allows the blade to be tilted up to 45 degrees to the left

To tilt the saw blade to an angle, loosen lock knob (D) Fig. 67, and turn handwheel (C) until the pointer (F) indicates the desired angle of tilt on scale (E). To lock the saw blade at the desired angle, tighten lock knob (D).

IMPORTANT: ALWAYS LOCK THE BLADE IN POSITION BEFORE APPLYING POWER TO THE SAW.

ADJUSTING 90 AND 45 DEGREE POSITIVE STOPS

Positive stops are provided to quickly and accurately position the blade at 90 and 45 degrees to the table. To check and adjust the positive stops, proceed as follows:

1. DISCONNECT SAW FROM POWER SOURCE.
2. Raise the saw blade all the way to the top and turn the blade tilting handwheel clockwise as far as it will go.
3. Using a combination square, check to see if the blade is 90 degrees to the table.
4. If an adjustment is necessary, turn the blade tilting handwheel counterclockwise one turn.
5. Loosen locknut (A) Fig. 68, and turn adjusting screw (B) counter clockwise, one turn.
6. Turn the blade tilting handwheel until the blade is 90 degrees to the table.
7. Turn adjusting head screw (B) clockwise, until it just contacts the casting on the front trunnion, then tighten locknut (A).
8. Check to see if the tilt indicator pointer points to the zero mark on the scale. Adjust if necessary.
9. Turn the blade tilting handwheel counterclockwise as far as it will go. Using a combination square, check to see if the blade is at 45 degrees to the table.
10. If an adjustment is necessary, turn the blade tilting handwheel clockwise one turn, until the adjusting screw (D) Fig. 69, and locknut (C) are in view, in the opening in the front of the saw cabinet, as shown in Fig. 69.

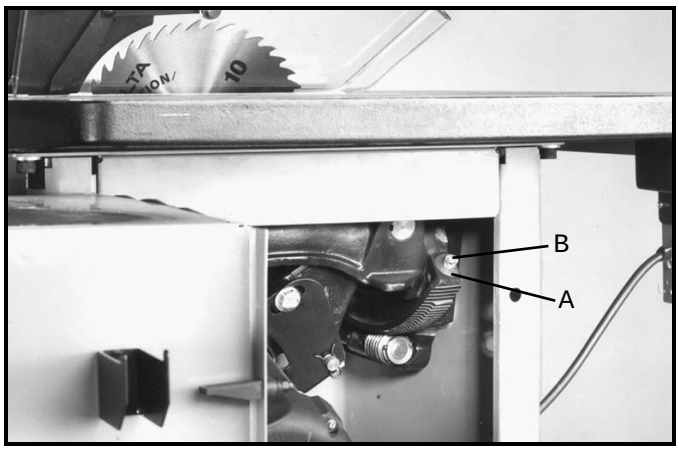

Fig. 68

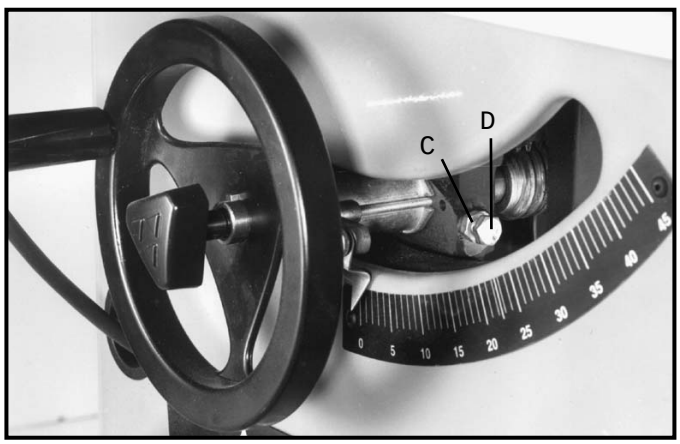

Fig. 69

11. Loosen locknut (C), and turn adjusting screw (D) counter clockwise, on turn.

12. Turn the blade tilting handwheel until the blade is 45 degrees to the table.

13. Turn adjusting head screw (D) clockwise, until it just contacts the casting on the front trunnion, then tighten locknut (C), until it is locked into place.

14. Check to see if the tilt indicator pointer points to the 45 degree mark on the scale. Adjust if necessary

ADJUSTING TABLE

The saw table has been aligned at the factory so the miter gage slots are parallel to the saw blade; however, it is recommended to check the alignment before initial operation as follows:

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE.

2. Place a combination square (A) Fig. 70, on the table with one edge of the square in the miter gage slot, as shown, and adjust the square so the rule just touches one of the teeth on the saw blade at the forward position, as shown in Fig. 70. Lock the square in this position.

3. Rotate the saw blade so that the same tooth you used in STEP 2 is in the rear position, as shown in Fig. 71, and check this distance. Both the front and rear measurements should be identical.

4. If an adjustment is necessary, loosen the four screws that hold the table to the saw cabinet.

5. Shift the table until a position is found which brings the saw blade in the center of the table insert slot, and parallel to the miter gage slot.

6. Tighten the four screws that were loosened in STEP 4.

MITER GAGE OPERATION AND ADJUSTMENT

Insert the miter gage bar into the miter gage slot and assemble the washer and lock handle (A) Fig. 72, to the miter gage bar as shown.

The miter gage is equipped with adjustable index stops at 90 degrees and 45 degrees right and left. Adjustment to the index stops can be made by tightening or loosening the three adjusting screws (B) Fig. 73.

To rotate the miter gage, loosen lock knob (A) Fig. 73, and move the body of the miter gage (C), to the desired angle.

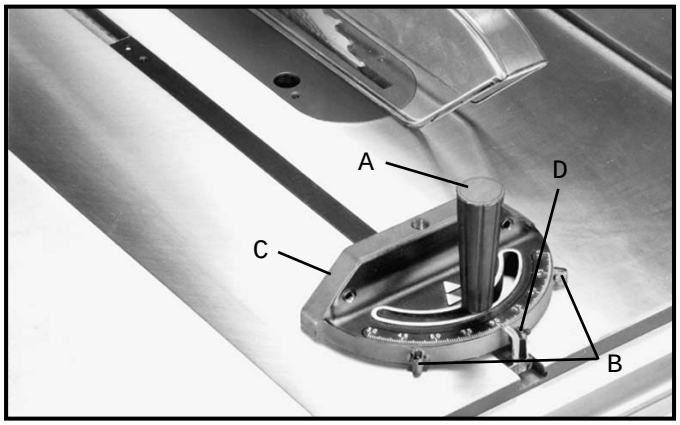

Fig. 73

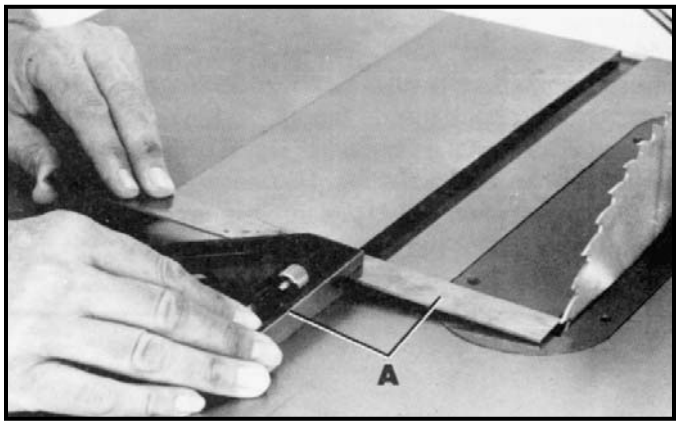

Fig. 70

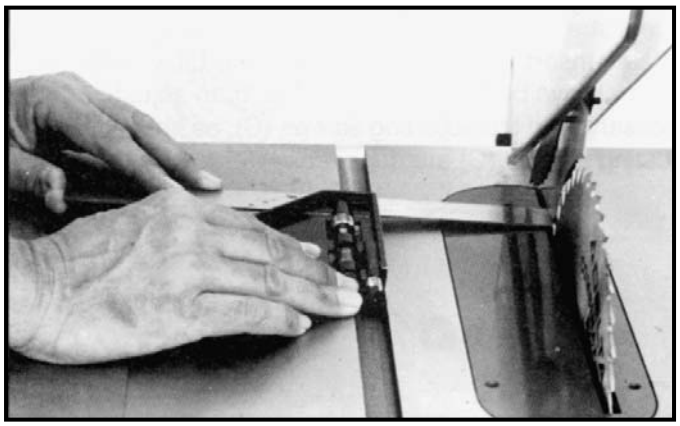

Fig. 71

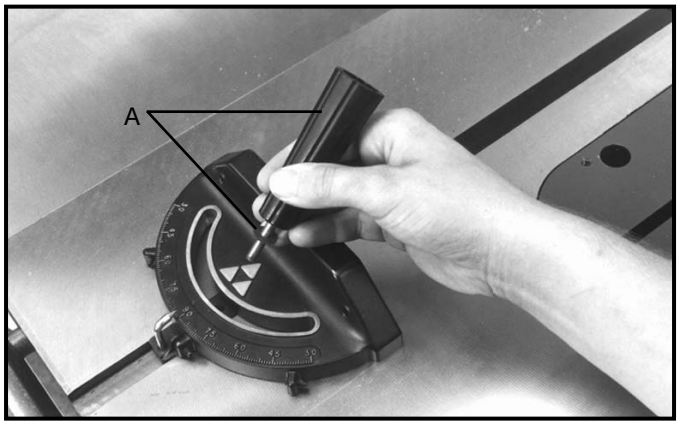

Fig. 72

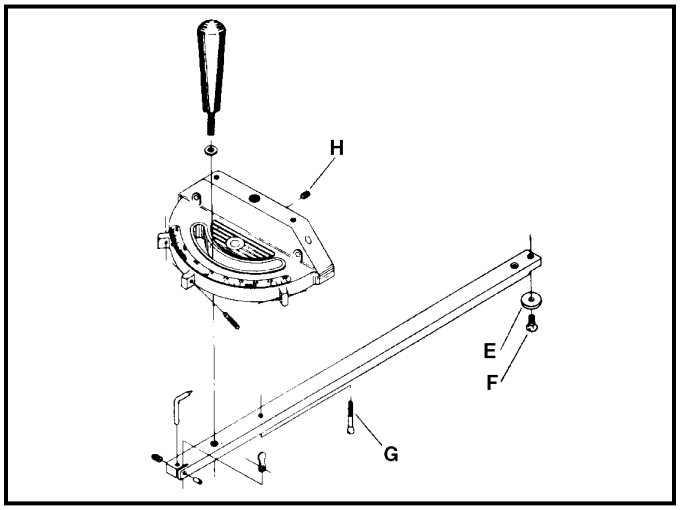

Fig. 74

The miter gage body will stop at 90 degrees and 45 degrees both right and left. To rotate the miter gage body past these points, the stop link (D) Fig. 73, must be moved up and out of the way.

The head of the miter gage pivots on a special tapered screw (G) Fig. 74, that fastens the head to the miter gage bar. If the miter gage head does not pivot freely, or pivots too freely, [illegible] turning the screw (G) in or out. Be certain to tighten screw (H) a[illegible]

MAINTEN[illegible]

CHANGING THE SAW BLADE

1. MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

2. NOTE: Two wrenches are supplied with the saw for changing the saw blade; a box end wrench and open end wrench.

3. Remove table insert and raise saw blade to its maximum height.

4. Place the open end wrench (B) Fig. 75, on the flats of the saw arbor to keep the arbor from turning, and using wrench (A), turn the arbor nut (C) counterclockwise. Remove arbor nut, blade flange and saw blade.

5. Assemble the new blade, making certain the teeth are pointing down at the front of the saw table and assemble outside blade flange and arbor nut. With wrench (B) Fig. 75, on the flats of the arbor to keep it from turning, tighten arbor nut by turning wrench (A) clockwise.

6. Replace table insert.

NOTE: Use only 10" saw blades with 5/8" arbor holes, rated for at least 3450 RPMs.

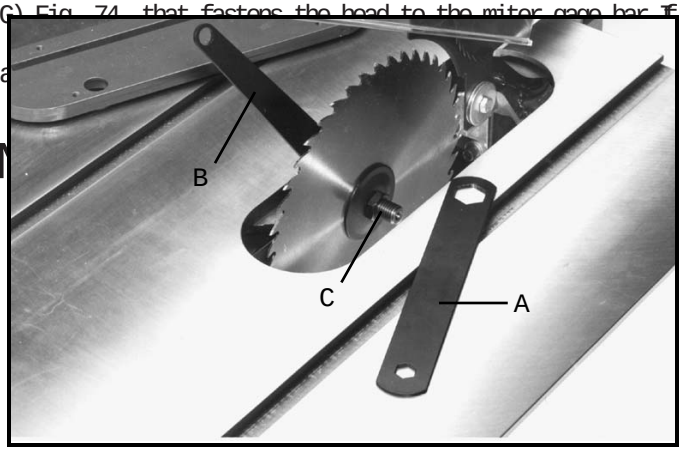

Fig. 75

REPLACING BELTS AND ADJUSTING BELT TENSION

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE.

2. Remove the blade and table insert, (see the section on CHANGING THE SAW BLADE).

3. Open motor cover door to gain access to the motor.

4. Place a block of wood (C) Fig. 76, between the motor and saw cabinet as shown. NOTE: It may be necessary to raise the saw arbor in order to insert the wooden block. Lower the saw arbor until the motor contacts the wood.

5. Loosen bolt (D) Fig. 76, and continue to lower the saw arbor until all tension is removed from the belts (E) Fig. 77 and tighten bolt (D) Fig. 76.

6. Raise the saw arbor slightly and remove the block of wood (C) Fig. 76.

7. Lower the saw arbor. Remove the belts (E) Fig. 76, one at a time from the motor pulley.

8. Remove the belts (E) Fig. 77, one at a time from the arbor pulley (F).

9. Assemble the three new belts, one at a time in the grooves of the arbor pulley (F) Fig. 77, and onto the motor pulley.

10. When the new belts are assembled on the arbor pulley (F) Fig. 77 and the motor pulley, loosen screw (D)

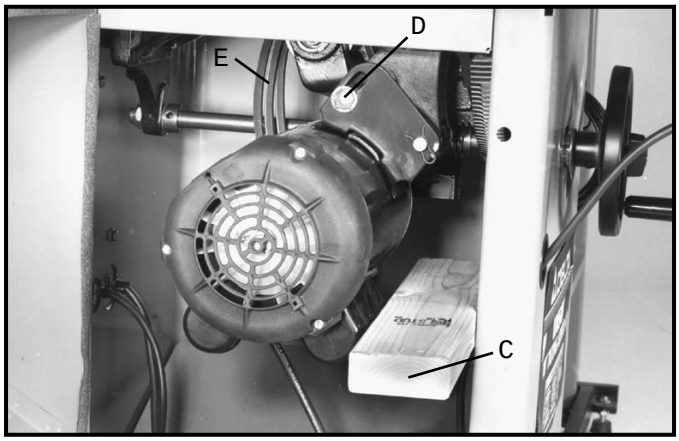

Fig. 76

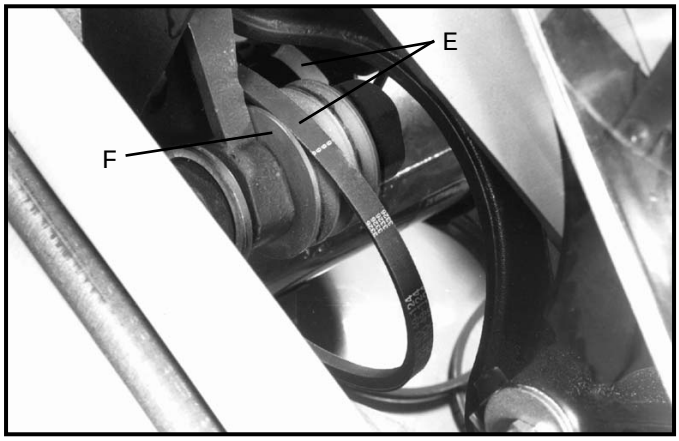

Fig. 77

Fig. 76, and carefully let the motor rest on the belts.

11. Correct belt tension is when there is approximately 1/4" deflection in the center span of the pulleys, using light finger pressure. After tension is applied, tighten screw (D) Fig. 76.

PROTECTING CAST IRON TABLE FROM RUST

To clean and protect cast iron tables from rust, you will need the following materials: A pushblock from a jointer, a sheet of medium Scotch-Brite Blending Hand Pad, a can of WD-40fi, a can of degreaser, a can of TopCote fi Aerosol. Apply the WD-40 fi and polish the table surface with the Scotch-Brite pad using the pushblock as a holddown. Degrease the table, then apply the TopCote fi .

OPERATION

Common sawing operations include ripping and crosscutting plus a few other standard operations of a fundamental nature. As with all power tools, there is a certain amount of hazard involved with the operation and use of the tool. Using the tool with the respect and caution demanded as far as safety precautions are concerned, will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or completely ignored, personal injury to the operator can result. The following information describes the safe and proper method for performing the most common sawing operations.

NOTE: THE USE OF ATTACHMENTS AND ACCESSORIES NOT RECOMMENDED BY DELTA MAY RESULT IN THE RISK OF INJURY TO PERSONS AND/OR DAMAGE TO THE TOOL.

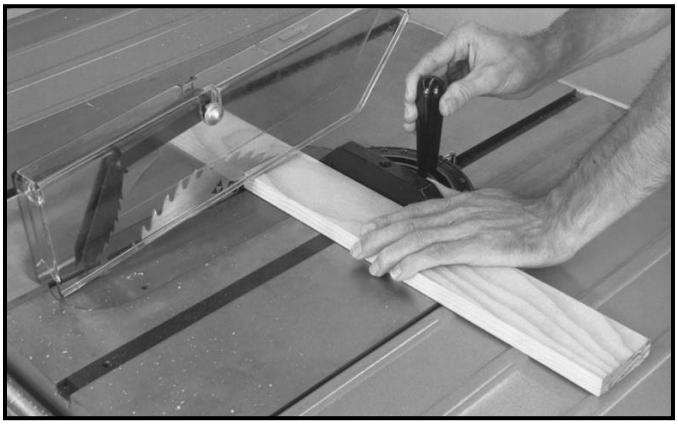

Fig. 78

CROSS-CUTTING

Cross-cutting requires the use of the miter gage to position and guide the work. Place the work against the miter gage and advance both the gage and work toward the saw blade, as shown in Fig. 78. The miter gage may be used in either table slot. When bevel cutting (blade tilted), use the right miter gage slot so that the blade tilts away from the miter gage and your hands.

Start the cut slowly and hold the work firmly against the miter gage and the table. One of the rules in running a saw is that you never hang onto or touch a free piece of work. Hold the supported piece, not the free piece that is cut off The feed in cross-cutting continues until the work is cut in two, and the miter gage and work are pulled back to the starting point. Before pulling the work back, it is good practice to give the work a little sideways shift to move the work slightly away from the saw blade. Never pick up any short length of free work from the table while the saw is running. A smart operator never touches a cutoff piece unless it is at least a foot long.

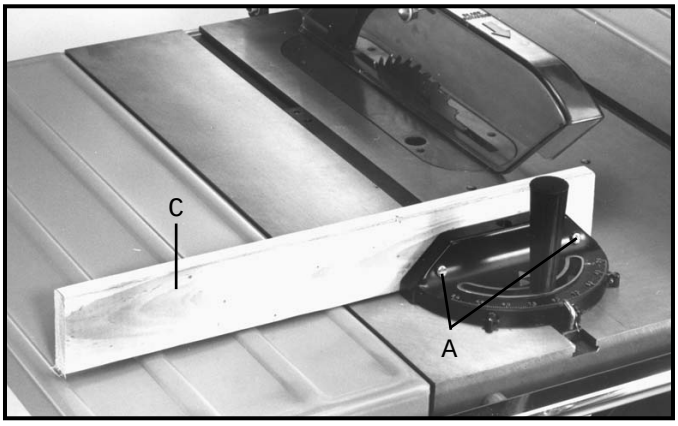

Fig. 79

For added safety and convenience the miter gage can be fitted with an auxiliary wood-facing (C), as shown in Fig. 79, that should be at least 1 inch higher than the maximum depth of cut, and should extend out 12 inches or more to one side or the other depending on which miter gage slot is being used. This auxiliary wood-facing (C) can be fastened to the front of the miter gage by using two wood screws (A) Fig. 79, through the holes provided in the miter gage body and into the wood-facing.

WARNING: NEVER USE THE FENCE AS A CUT-OFF GAGE WHEN CROSS-CUTTING.

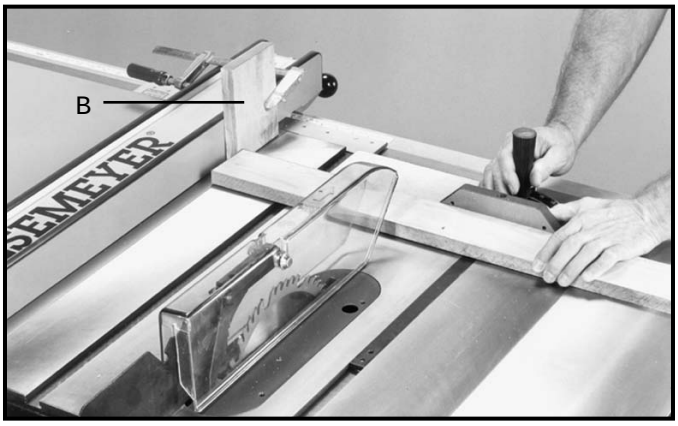

Fig. 80

When cross-cutting a number of pieces to the same length, a block of wood (B), can be clamped to the fence and used as a cut-off gage as shown in Fig. 80. It is important that this block of wood always be positioned in front of the saw blade as shown. Once the cut-off length is determined, secure the fence and use the miter gage to feed the work into the cut.

This block of wood allows the cut-off piece to move freely along the table surface without binding between the fence and the saw blade, thereby lessening the possibility of kickback and injury to the operator.

RIPPING

Ripping is the operation of making a lengthwise cut through a board, as shown in Fig. 81, and the rip fence (A) is used to position and guide the work. One edge of the work rides against the rip fence while the flat side of the board rests on the table. Since the work is pushed along the fence, it must have a straight edge and make solid contact with the table. The saw guard must be used. The guard has anti-kickback fingers to prevent kickback, and a splitter to prevent the wood from closing behind the blade.

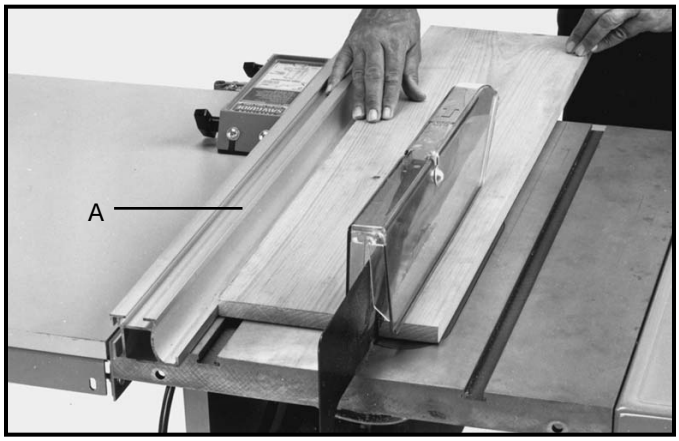

Fig. 81

Start the motor and advance the work holding it down and against the fence. Never stand in the line of the saw cut when ripping. Hold the work with both hands and push it along the fence and into the saw blade as shown in Fig. 81. The work can then be fed through the saw blade with one or two hands. After the work is beyond the saw blade and anti-kickback fingers, the hand is removed from the work. When this is done the work will either stay on the table, tilt up slightly and be caught by the rear end of the guard or slide off the table to the floor. Alternately, the feed can continue to the end of the table, after which the work is lifted and brought back along the outside edge of the fence. The cut-off stock remains on the table and is not touched with the hands until the saw blade is stopped, unless it is a large piece allowing safe removal. When ripping boards longer than three feet, it is recommended that a work support be used at the rear of the saw to keep the workpiece from falling off the saw table.

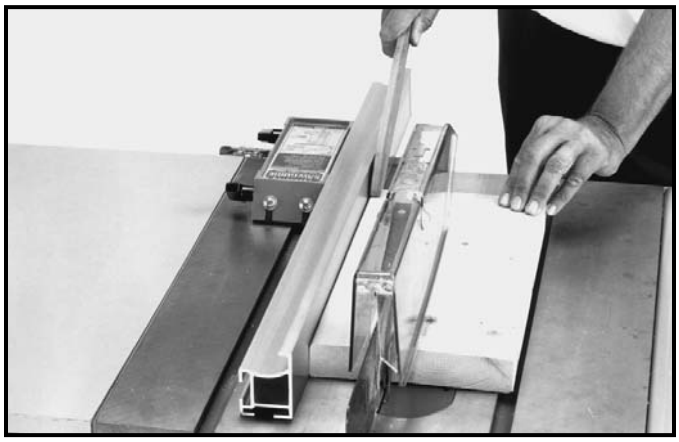
Fig. 82

If the ripped work is less than 4 inches wide, a push stick should always be used to complete the feed, as shown in Fig. 82. The push stick can easily be made from scrap material as explained in the section CONSTRUCTING A PUSH STICK. When ripping stock 2 inches or narrower, assemble an auxiliary wood facing to the fence, as explained in the section USING AUXILIARY WOOD FACING ON RIP FENCE and use a push stick.

USING ACCESSORY MOULDING CUTTERHEAD

Moulding is cutting a shape on the edge or face of the work. Cutting mouldings with a moulding cutterhead in the circular saw is a fast, safe and clean operation. The many

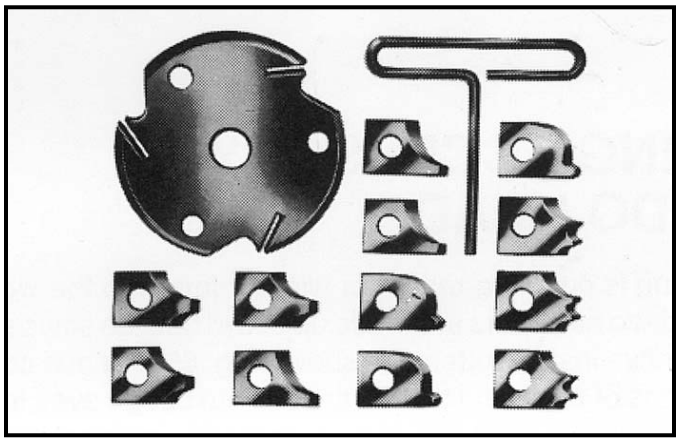
Fig. 83

Fig. 84

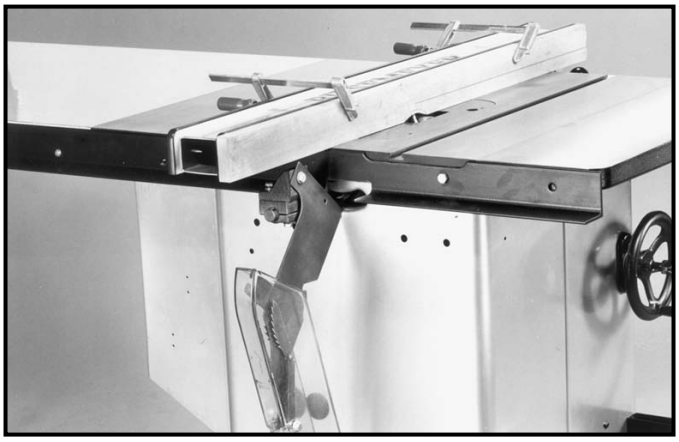

Fig. 85

different knife shapes available make it possible for the operator to produce almost any kind of mouldings, such as various styles of corner moulds, picture frames, table edges, etc.

The moulding head consists of a cutterhead in which can be mounted various shapes of steel knives, as shown in Fig. 83. Each of the three knives in a set is fitted into a groove in the cutterhead and securely clamped with a screw. The knife grooves should be kept free of sawdust, which would prevent the cutter from seating properly.

IMPORTANT: For certain cutting operations such as dadoing and moulding where you are not cutting completely through the workpiece, the blade guard and splitter assembly cannot be used. Loosen screws (G) and (H) Fig. 84. Lift up and swing blade guard and splitter assembly (W) Fig. 84, to the rear of the saw as shown in Fig. 85. CAUTION: Always return and fasten the blade guard and splitter assembly to its proper operating position for normal thru-sawing operations.

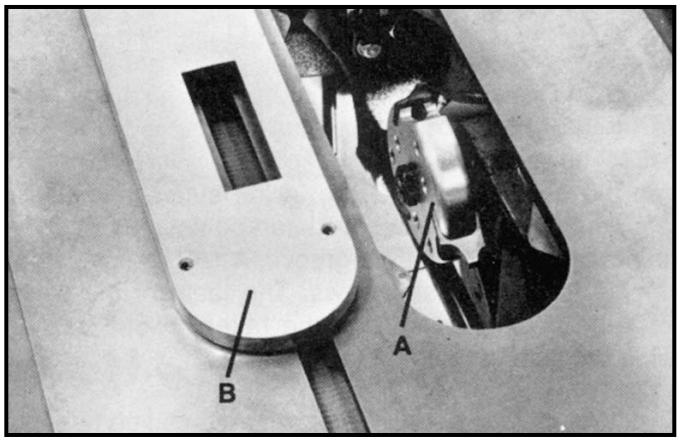

Fig. 86

The moulding cutterhead (A) Fig. 86, is assembled to the saw arbor as shown. Also, the accessory moulding cutterhead table insert (B), must be used in place of the standard table insert.

It is necessary when using the moulding cutterhead to add wood-facing (C) to the face of the rip fence, as shown in Fig. 87. The wood-facing is attached to the fence with two clamps, as shown in Fig. 85. When attaching wood facing to a fence, 3/4 inch stock is usually suitable for most work, although an occasional job may require 1 inch facing.

Position the wood-facing over the cutterhead with the cutterhead below the surface of the table. Turn the saw on and raise the cutterhead. The cutterhead will cut its own groove in the wood-facing. Fig. 87, shows a typical moulding operation. NEVER USE MOULDING CUTTERHEAD IN A BEVEL POSITION.

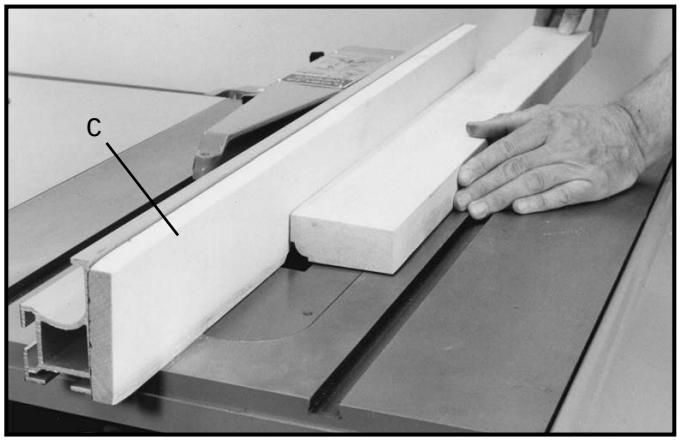

Fig. 87

IMPORTANT: NEVER RUN THE STOCK BETWEEN THE FENCE AND THE MOULDING CUTTERHEAD AS IRREGULAR SHAPED

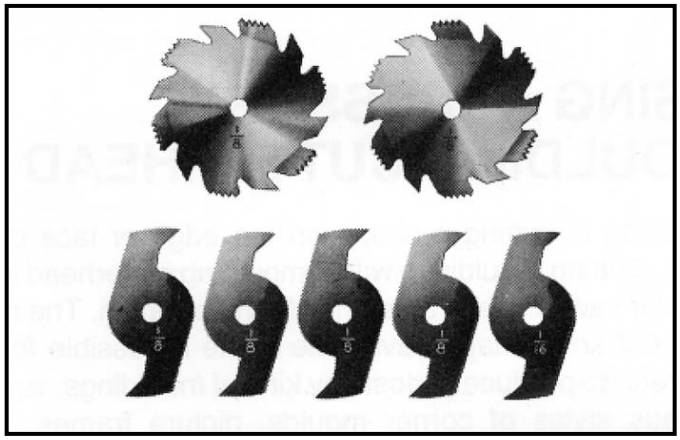

Fig. 88

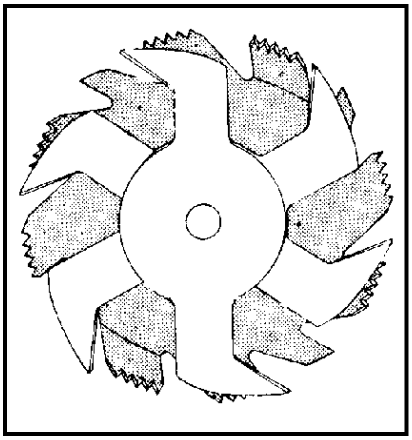

Fig. 89

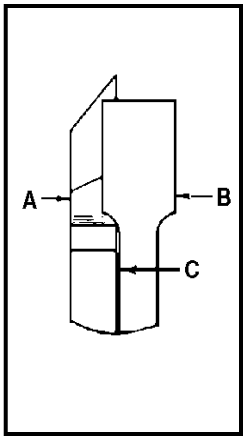

Fig. 90

WOOD WILL CAUSE KICKBACK.

When moulding end grain, the miter gage is used. The feed should be slowed up at the end of the cut to prevent splintering.

In all cuts, attention should be given the grain, making the cut in the same direction as the grain whenever possible.

ALWAYS INSTALL BLADE GUARD AFTER OPERATION IS COMPETE. USING ACCESSORY DADO HEAD

IMPORTANT: THE BLADE GUARD AND SPLITTER ASSEMBLY CANNOT BE USED WHEN DADOING OR MOULDING AND MUST BE REMOVED OR SWUNG TO THE REAR OF THE SAW.

Dadoing is cutting a rabbet or wide groove into the work. Most dado head sets are made up of two outside saws and four or five inside cutters, as shown in Fig. 88. Various combinations of saws and cutters are used to cut grooves from 1/8" to 13/16" for use in shelving, making joints, tenoning, grooving, etc. The cutters are heavily swaged and must be arranged so that this heavy portion falls in the gullets of the outside saws, as shown in Fig. 89. The saw and cutter overlap is shown in Fig. 90, (A) being the outside saw, (B) an inside cutter, and (C) a paper washer or washers which can be used as needed to control the exact width of groove. A 1/4" groove is cut by using the two outside saws. The teeth of the saws should be positioned so that the raker on one saw is beside the cutting teeth on the other saw.

The dado head set (D) Fig. 91, is assembled to the saw arbor as shown. IMPORTANT: The blade guard and splitter assembly cannot be used when dadoing and must be removed or swung to the rear of the saw as explained previously in this manual. Auxiliary jigs, fixtures, push

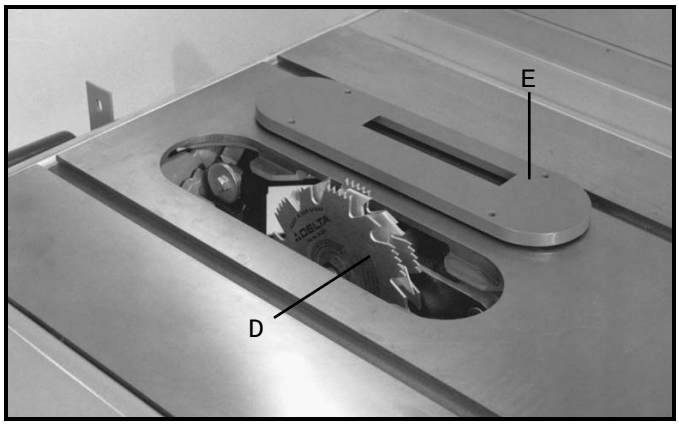

Fig. 91

Fig. 92

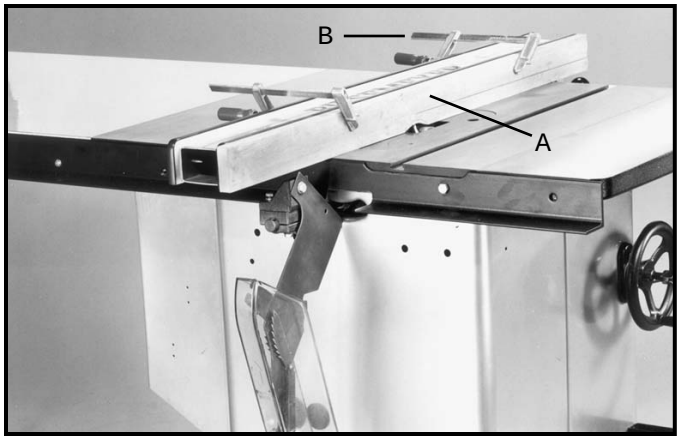

Fig. 93

Fig. 94

sticks and feather boards should also be used. Also, the accessory dado head table insert (E) Fig. 91, must be used in place of the standard table insert.

Fig. 92, shows a typical dado operation using the miter gage as a guide.

WARNING: NEVER USE THE DADO HEAD IN A BEVEL POSITION.

IMPORTANT: ALWAYS INSTALL BLADE GUARD AFTER OPERATION IS COMPLETED.

USING AUXILIARY WOOD FACING ON RIP FENCE

It is necessary when performing special operations such as moulding to add wood facing (A) Fig. 93, to one or both sides of the rip fence, as shown. The wood facing is attached to the fence with two clamps (B). ¾ inch stock is suitable for most work although an occasional job may require 1 inch facing.

A wood facing should be used when ripping thin material

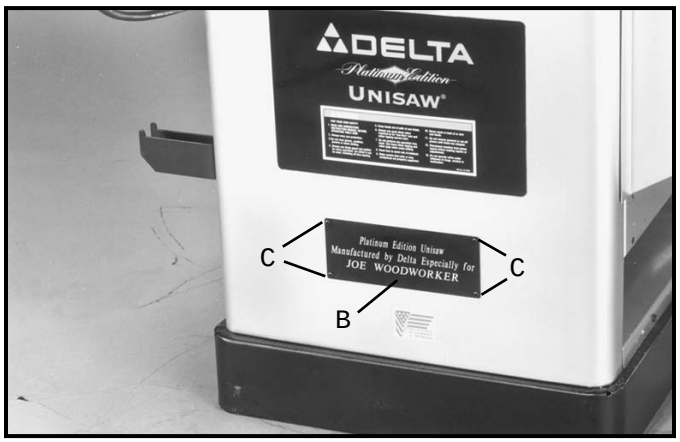

Fig. 95

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